

WEB CONVEYING APPARATUS, AND APPARATUS AND METHOD FOR
ELECTRODEPOSITION USING WEB CONVEYING APPARATUS

BACKGROUND OF THE INVENTION

5 Field of the Invention

The present invention relates to a conveying apparatus for conveying a web (a elongated substrate) used as elements or parts with functional film formed thereon, which is wound up in coil form and handled in the apparatus. The present invention, specifically relates to a web conveying apparatus wherein when a web in coil form is unwound for film deposition and then rewound up in coil form, expansion or wrinkle does not occur at the web edges and the web is conveyed along its predetermined path without strain then wound up in coil form with edge alignment. The present invention also relates to a electrodeposition apparatus and a electrodeposition method using such a web conveying apparatus.

20 Related Background Art

When films are continuously stacked on metal sheet, for example, a steel sheet or a stainless steel sheet, as a substrate, on which solar cells can be formed, a commercially effective production of webs can be performed by making a web into a spool in coil or roll form, passing it through stack deposition process while unwinding the coil for delivery, and rewinding up

the web in coil form. However, in order to implement such a mechanism, it is important that a web is conveyed in a stack deposition process without meandering and that wind-up misalignment does not occur in winding up. In particular, when the length of an unwound web is large, even very small convey deviation causes large misalignment at the wind-up portion. It is also difficult to correct a web where misalignment once occurred, in the case of a metal where elastic deformation range is very small.

A conveying system which the invention is directed to, and wherein web misalignment does not occur, is disclosed USP 4,485,125 ("Method for continuously producing tandem amorphous photovoltaic cells", Energy Conversion Devices, November 27, 1984). In this invention (refer to Fig. 9 in USP 4,485,125), deviation of a web is detected by using a optical-based, light-blocking edge detector, and the output signal is fed back to a servomotor, and output of the servomotor is transmitted through a link mechanism to a wheel gear that is provided on one end face of a roller with being eccentric to the axis of the roller, so that the axis of the roller is tilted and tension applied to the web at one side of the roller is varied with respect to tension at the other side of the roller, so as to axially move the web.

USP 4,664,951 ("Method provided for corrective

lateral displacement of a longitudinally moving web held in a planar configuration", Energy Conversion Devices, May 12, 1987) suggests to prevent warping or deformation of a web by using a magnet roller to
5 prevent the web from rocking and eliminate deviation of the convey path.

Japanese Patent Application Laid-Open No. 5-270710 ("meandering correction mechanism for web, Toppan Printing Co., LTD., laid opened to public on October
10 19, 1993) discloses a mechanism wherein web meandering is corrected by varying the direction of a guide roll (the term "roller" in the invention has same meaning as "roll(s)" mentioned in above example for conventional art, and so forth.), or axially moving the roll. In
15 fact, this invention intends to combine varying direction of the guide role and axially moving the roll, which effects easily coarse meandering correction but does not effect easily fine meandering correction, since when the amount of meandering is large, if
20 direction of the guide roll is only changed, wrinkles may occur and meandering correction may not be possible.

Japanese Patent Application Laid-Open No. 6-239508 ("controlling apparatus for web travel", Shin-Oji
25 Paper, laid opened to public on August 30, 1994.) discloses a meandering correction mechanism wherein fixed roles and displacement rolls are combined. This

invention intends that when correcting web meandering on the displacement rolls that turn back a web between fixed rolls, relative positioning between the displacement rolls are implemented by a press-contact
5 force regulation mechanism.

Moreover, Japanese Patent Application Laid-Open No. 10-296317 (a metal strip conveying apparatus, made open to public by Nippon Steel on November 10, 1998) describes a method to prevent zigzag movement with
10 combination of a free loop, a pinch roller and a crown roll.

As a related art, Japanese Patent Application Laid-Open No. 8-197124 (a method to control zigzag movement of metal plates) discloses a system to form a
15 catenary and judge zigzag amounts from difference in catenary level at the both ends so as to adjust the zigzag by tilting an axis of a roll. Forming catenaries positively is adopted often in order to adjust velocity in case of conveying metal plates and
20 the like.

Incidentally, in case of forming functional film on a metal web, whether it is CVD method in a vacuum apparatus, a sputtering method, a heat evaporation method, or an electrodeposition method being a wet
25 system filming, the relationship with the opposite electrode requires rather serious care. In addition, from the point of view to prevent cut or contamination,

etc., it is preferable to cause the filmed surface to avoid contact with a roller, etc. as much as possible. Moreover, it is advisable that sandwiching it with a pair of rollers as often conducted in a rotary press or
5 a rolling apparatus is not adopted from the like point of view.

Thus, as in USP4,485,125, when to convey a web, adopted is such a technique to apply a constant tension between a delivery roller and a wind-up roller so that
10 the object is conveyed with a supporting roller applied from a rear surface of the web (the opposite side of a filmed surface of the function film) in almost all cases. In the case where magnetic SUS, etc. is used as a web, it is also possible to convey in a suspended
15 fashion assisted by a magnet roller as in USP4,664,951. Accordingly, in general, it is not a common practice to form a catenary or "slack" positively as disclosed in Japanese Patent Application Laid-Open No. 8-197124.

The present inventors have tried to produce an
20 electrodeposition apparatus as shown in Fig. 2 and to form an oxide on the web of SUS430. A general configuration as well as operation of the actually produced electrodeposition apparatus is shown in Fig. 2. Moreover, divided and enlarged views thereof are
25 shown in Fig. 3 to Fig. 9. Fig. 2 as well as Fig. 3 to Fig. 9 shares common names and reference numerals for respective portions.

Procedure to film or deposit an electrodeposited film onto the web in which the present apparatus was used will be described with reference to Fig. 2 and Fig. 3 to Fig. 9.

5 The apparatus roughly breaks down to a wind-off apparatus 2012 to deliver a coiled web, a first electrodeposition vessel 2066 to cause the first electrodeposited film to be processed or deposited, a second electrodeposition vessel 2116 to cause the
10 second electrodeposited film to be deposited or processed, a first circulating vessel 2120 to circulate-supply a heated electrodeposition bath to the first electrodeposition vessel, a second circulating vessel 2222 to circulate-supply a heated
15 electrodeposition bath to the second electrodeposition vessel, a first discharging vessel 2172 to temporarily store the bath when to discharge the electrodeposition bath in the first electrodeposition vessel, a second discharging vessel 2274 to temporarily store the bath
20 when to discharge the electrodeposition bath in the second electrodeposition vessel, a filter circulation system to clean the bath by removing powder in the electrodeposition bath inside the first electrodeposition vessel (a pipe system linked to the
25 first electrodeposition vessel filter circulation filter 2161), a filter circulation system to clean the bath by removing powder in the electrodeposition bath

inside the second electrodeposition vessel (a pipe system linked to the second electrodeposition vessel filter circulation filter 2263), a pipe system to deliver compressed air for bath mixing respectively to

5 the first electrodeposition bath and the second electrodeposition bath (a pipe system with the compressed air introducing orifice 2182 in origin), a pure water shower vessel 2360 to clean a web on which an electrodeposited film was deposited with a shower of

10 pure water, a first warm water vessel 2361 to execute first pure water rinse cleaning, a second warm water vessel 2362 to execute second pure water rinse cleaning, a pure water heating vessel 2339 to supply these warm water vessels with necessary pure warm

15 water, a dryer section 2363 to dry the cleaned web, a wind-up apparatus 2296 to wind up again into a coil form the web which completed film depositing, and a system to discharge steam which is created during an electrodeposition both, a heating stage or a drying

20 state on pure water (exhausting system configured by an exhausting duct 2020 of the electrodeposition water cleaning system or an exhausting duct 2370 of the dryer system).

The web is conveyed sequentially from left to

25 right in the drawings via the wind-off apparatus 2012, the first electrodeposition vessel 2066, the second electrodeposition vessel 2116, the pure water shower

vessel 2360, the first warm water vessel 2361, the second warm water vessel 2362, the dryer section 2363 and wind-up apparatus 2296 so that a predetermined electrodeposited film is deposited.

5 As shown in Fig. 3, a coiled web 2006 which is coiled around the wind-off apparatus web bobbin 2001 is set in the wind-off apparatus 2012, which goes on delivering the web 2006 via the wind-off apparatus delivery control roller 2003, the wind-off apparatus direction change roller 2004 and the wind-off apparatus discharging roller 2005. The coiled web is supplied with an interleaf (slipsheet) being sandwiched to protect a substrate or a layer in the case where an underlining layer is deposited in advance in particular. Therefore, in the case where the interleaf is coiled in, along with wind-off of the web the interleaf 2007 is wound up by a wind-off apparatus interleaf wind-up bobbin 2002. The conveying direction of the web 2006 is indicated by an arrow 2010, the rotating direction of the wind-up apparatus web bobbin 2010 is indicated by an arrow 2009, and the wind-up direction of the wind-off apparatus interleaf wind-up bobbin 2002 is indicated by an arrow 2008. In the drawing, the web discharged from the wind-off apparatus web bobbin 2001 and the interleaf wound up by the wind-off apparatus interleaf wind-up bobbin 2002 respectively indicates that interference has not taken

place at a position at the time when conveyance starts
and at a position at the time when conveyance ends.
The wind-off apparatus in its entirety is configured so
as to be covered by the wind-off apparatus clean booth
5 2011 using a HEPA filter and a down flow for protection
against dust.

The first electrodeposition vessel 2066 is, as
shown in Fig. 4, held in the first electrodeposition
bath holding vessel 2065 that can keep the
10 electrodeposition bath warm without being corrosive to
the electrodeposition bath so that the temperature
controlled electrodeposition bath will be the first
electrodeposition bath bath surface 2025. The position
of this bath surface is realized with over flow by the
15 partition provided inside the first electrodeposition
bath holding vessel 2065. The not-shown partition is
installed so as to drop the electrodeposition bath
toward the depth of the first electrodeposition bath
holding vessel 2065, and the overflow electrodeposition
20 bath focused to the first electrodeposition vessel
overflow return orifice 2024 with a bucket structure
reaches the first circulating vessel 2120 via the first
electrodeposition vessel overflow return path 2117, and
is heated here to flow back again from the first
25 electrodeposition upstream circulation nozzle tube 2063
and the first electrodeposition downstream circulation
nozzle tube 2064 to the first electrodeposition bath

holding vessel 2065 so as to form inflow of the electrodeposition bath sufficient to urge an overflow.

The web 2006 passes inside the first electrodeposition vessel 2066 via a electrodeposition vessel entrance return roller 2013, a first electrodeposition vessel approach roller 2014, a first electrodeposition vessel withdraw roller 2015, and an inter-electrodeposition return roller 2016. Between the first electrodeposition vessel approach roller 2014 and the first electrodeposition withdraw roller 2015, at least the lower side face of the web being a filmed surface (to be referred to as "front face" in the present specification) is in the electrodeposition bath, opposing 28 units of anodes 2026 to 2053. The actual electrodeposition is executed by giving a negative potential to the web and a positive potential to the anode and by causing an electrodeposition current accompanied by electrochemical reaction to flow between the both parties in the electrodeposition bath.

In an apparatus in Fig. 2, the anode in the first electrodeposition vessel comprises four units each are mounted on seven anode mounting stands 2054 to 2060 (See Fig. 4). An anode mounting stand is structured so that the respective anodes are put via insulating plates and individual potentials are applied from an independent power supply. In addition, the anode mounting stands 2054 to 2060 are assigned to function

to hold gaps between the web and the anodes 2026 to 2053 in the electrodeposition bath. Therefore, normally, the anode amounting stands 2054 to 2060 are designed and produced so as to be capable of adjusting
5 height to hold a predetermined gap.

A first electrodeposition vessel rear surface electrode 2061 provided to immediately precede the first electrodeposition vessel withdraw roller 2015 is the one to remove electrochemically the film deposited
10 on the opposite face against the filmed surface of the web (to be referred to as "rear face" in the present specification), and this is realized by taking the first electrodeposition vessel rear face electrode 2061 as the negative side potential against the web. The
15 fact that the first electrodeposition rear face electrode 2061 is actually effective is confirmed in that a film, which is attached electrochemically onto the rear face in the opposite side of the filmed surface of the web by a wraparound electric field,
20 having the same quality as that of the film formed on the filmed surface of the web, is rapidly removed under visual observation.

To the web having come out from the electrodeposition bath after passing through the first
25 electrodeposition vessel withdraw roller 2015, the electrodeposition bath is applied from the first electrodeposition vessel exit shower 2067 so as to

prevent the filmed surface from being dried and giving rise to surface irregularity. In addition, an inter-electrodeposition cover 2019 provided in the bridge portion between the first electrodeposition vessel 2066 and the second electrodeposition vessel 2116 also shuts the steam generated from the electrodeposition vessel and prevent the filmed surface of the web from being dried. Moreover, a second electrodeposition vessel entrance shower 2068 functions to prevent from being dried as well.

The first circulating vessel 2120 is in charge of heating and keeping warm the electrodeposition bath and jet circulation thereof inside the first electrodeposition vessel 2066. As described above, the electrodeposition bath having overflowed in the first electrodeposition vessel 2066 is collected into the first electrodeposition vessel overflow return orifice 2024, passes the first electrodeposition vessel overflow return path 2117, and reaches the first circulation vessel heat storage vessel 2121 via the first electrodeposition vessel overflow return path insulating flange 2118. Inside the first circulation vessel heat storage vessel 2121, eight units the first circulation vessel heaters 2122 to 2129 are provided, and these functions at the time when an electrodeposition bath under room temperature is initially heated or at the time when the

electrodeposition bath losing its bath temperature due to circulation is heated again to hold the electrodeposition bath at a predetermined temperature.

Two circulation systems are connected with the
5 first circulation vessel heat storage vessel 2121.
That is, one is the first electrodeposition vessel
upstream circulation return current system to return
from the first electrodeposition vessel upstream
circulation nozzle tube 2063 to the first
10 electrodeposition bath holding vessel 2065 via a first
circulation vessel electrodeposition bath upstream
circulation origin valve 2130, a first circulation
vessel electrodeposition bath upstream circulation pump
2132, a first circulation vessel electrodeposition bath
15 upstream circulation valve 2135, a first circulation
vessel electrodeposition bath upstream circulation
flexible pipe 2136 and a first circulation vessel
electrodeposition bath upstream circulation flange
insulation pipe 2137 and the other is the first
20 electrodeposition vessel downstream circulation return
current system to return from the first
electrodeposition vessel downstream circulation nozzle
tube 2064 to the first electrodeposition bath holding
vessel 2065 via a first circulation vessel
25 electrodeposition bath downstream circulation origin
valve 2139, a first circulation vessel
electrodeposition bath downstream circulation pump

2142, a first circulation vessel electrodeposition bath downstream circulation valve 2145, a first circulation vessel electrodeposition bath downstream circulation flexible valve 2148 and a first circulation vessel electrodeposition bath downstream circulation flange insulation pipe 2149. The electrodeposition bath returning from the first electrodeposition vessel upstream circulation nozzle tube 2063 and the first electrodeposition vessel downstream circulation nozzle tube 2064 to the first electrodeposition vessel 2066 is caused to flow back as a jet stream from the first electrodeposition vessel upstream circulation nozzle tube 2063 provided in the lower portion of the first electrodeposition bath holding vessel 2065 and the first electrodeposition vessel downstream circulation nozzle tube 2064 via orifices respectively created by piercing the nozzle tubes so as to effectuate the electrodeposition bath exchange inside the first electrodeposition bath holding vessel 2065. The return amounts in the respective circulation return current systems are controlled by a closing level of the first circulation vessel electrodeposition bath upstream circulation valve 2135 or the first circulation vessel electrodeposition bath downstream circulation valve 2145, and further delicate adjustment is controlled by a first circulation vessel electrodeposition bath upstream circulation pump bypass valve 2133 or a first

circulation vessel electrodeposition bath downstream
circulation pump bypass valve 2141 provided in a bypass
system which has been brought into connection by short-
circuiting the exit and the entrance of the first
5 circulation vessel electrodeposition bath upstream
circulation pump 2132 or the first circulation vessel
electrodeposition bath downstream circulation pump
2142. The bypass systems function to prevent
cavitation from taking place inside the pumps in the
10 case where the return current amount is made less or at
the time when the bath temperature is extremely close
to the boiling point. Cavitation under which the bath
fluid is boiled and evaporated so that a liquid is no
longer deliverable will remarkably shorten the life of
15 the pumps.

In the case where orifices are pierced in the
first circulation vessel electrodeposition bath
upstream circulation nozzle tube 2063 and the first
circulation vessel electrodeposition bath downstream
20 circulation nozzle tube 2064 to form a jet stream, the
return current amount is almost determined by the
pressure to bring back the bath fluid to the first
circulation vessel electrodeposition bath upstream
circulation nozzle tube 2063 and the first circulation
25 vessel electrodeposition bath downstream circulation
nozzle tube 2064. In order to know this, a first
circulation vessel electrodeposition bath upstream

circulation pressure gage 2134 and a first circulation vessel electrodeposition bath downstream circulation pressure gage 2143 are provided so that the balance in the return current amounts can be known with these pressure gages. The return current bath fluid amount discharged from the orifices exactly follow the Verneuil's theorem, but with orifices pierced in the nozzle tubes having a diameter of not more than several millimeters the jet stream amount all over the first electrodeposition vessel upstream circulation nozzle tube 2063 to the first electrodeposition vessel downstream circulation nozzle tube 2064 can be treated as a constant in a practical term. Moreover, in the case where the return current amounts are sufficiently large, the bath can be exchanged extremely smoothly so that in spite of rather long first electrodeposition vessel 2066 uniformity of the bath density as well as uniformity of the temperature thereof can be planned effectively. It goes without saying that the first electrodeposition vessel overflow return path 2117 should have this thickness cable of flowing a sufficient return current amount.

The first circulation vessel electrodeposition bath upstream circulation flexible pipe 2136 and the first circulation vessel electrodeposition bath downstream circulation flexible pipe 2148 provided in the respective circulation return current systems are

to absorb deformation in pipe systems, and in particular are effective in the case where flange insulation pipes, etc. which are apt to suffer from shortage of mechanical intensiveness against deformation. The first circulation vessel electrodeposition bath upstream circulation flange insulation pipe 2137 and the first circulation vessel electrodeposition bath downstream circulation flange insulation pipe 2149 provided in the respective circulation return current systems cause the first circulation vessel 2120 and the first electrodeposition vessel 2066 to float electrically together with the first electrodeposition vessel overflow return path insulation flange 2118 provided in midway of the first electrodeposition vessel overflow return path 2117. This is based on knowledge of the present inventors that giving up formation of unnecessary current route, that is, prevention of stray currents leads to steady and effective progress of electrochemical filming reaction utilizing electrodeposition currents.

The other circulation return current system, is provided with a bypass return current system configured by a first circulation vessel electrodeposition bath bypass circulation flexible pipe 2146 and a first circulation vessel electrodeposition bath bypass circulation flexible valve 2147 to return to a first circulation vessel heat storage vessel 2121 directly,

and this is to be used in the case where bath circulation is desired to be executed without the bath fluid is returned to the first electrodeposition vessel, for example, at the time when temperature rises
5 from room temperature to predetermined temperature and the like. In addition, one circulation return current system from the first circulation vessel is provided with a fluid delivery system reaching to the first electrodeposition exit shower 2067 to apply the
10 electrodeposition bath to the web which has passed the first electrodeposition vessel withdraw roller 2015 and come out from the electrodeposition bath, which leads to the first electrodeposition exit shower 2067 via the first electrodeposition exit shower valve 2150. An
15 electrodeposition liquid spray amount from the first electrodeposition exit shower 2067 is adjusted by adjusting the closing level of the first electrodeposition exit shower valve 2150.

Practically, the first circulation vessel heat
20 storage vessel 2121 is provided with a cover so as to be structured to prevent water from becoming steam and going away. In the case where the bath temperature is high, the temperature of the cover will rise, and therefore consideration of sticking an insulating
25 material and the like is necessary from the point of view of safety.

For removing powder of the first electrodeposition

vessel electrodeposition bath, a filter circulation system is provided. The filter circulation system for the first electrodeposition vessel is configured by a first electrodeposition vessel filter circulation

5 return flexible pipe 2151, a first electrodeposition vessel filter circulation return flange insulation pipe 2152, a first electrodeposition vessel filter circulation origin valve 2154, a first electrodeposition vessel filter circulation suction

10 filter 2156, a first electrodeposition vessel filter circulation pump 2157, a first electrodeposition vessel filter circulation pump bypass valve 2158, a first electrodeposition vessel filter circulation pressure switch 2159, a first electrodeposition vessel filter

15 circulation pressure gage 2160, a first electrodeposition vessel filter circulation filter 2161, a first electrodeposition vessel filter circulation flexible pipe 2164, a first electrodeposition vessel filter circulation flange

20 insulation pipe 2165, a first electrodeposition vessel filter circulation valve 2166, a first electrodeposition vessel filter circulation system electrodeposition bath upstream return valve 2167, a first electrodeposition vessel filter circulation

25 system electrodeposition midstream return valve 2168 and a first electrodeposition vessel filter circulation system electrodeposition bath downstream return valve

2169. Along this route, the electrodeposition bath will flow in the direction of the first electrodeposition vessel filter circulation direction 2155, ditto 2162 and ditto 2163. The powder to be removed could be plunged in from outside the machine, or could be formed on the electrode surface or in the bath corresponding with the electrodeposition reaction. The minimum size of the powder to be removed is determined by the filter size of the first electrodeposition vessel filter circulation filter 2161.

The first electrodeposition vessel filter circulation return flexible pipe 2151 and the first electrodeposition vessel filter circulation flexible pipe 2164 absorb deformation of pipes to minimize leakage of liquid from pipe connecting portions, to protect insulation pipes which are inferior in mechanical intensity and to freedom in disposition of components of the circulation system including pumps. The purpose of the first electrodeposition vessel filter circulation return flange insulation pipe 2152 as well as the first electrodeposition vessel filter circulation flange insulation pipe 2165 is to cause the first electrodeposition bath holding vessel 2065 which is floating above the ground earth to float in order to prevent it from dropping onto the ground earth. The first electrodeposition vessel filter circulation

suction filter 2156, which is a metal mesh or, so to speak, a "tea strainer", removes a large dusts so as to protect succeeding first electrodeposition vessel filter circulation pump 2157 or the first

5 electrodeposition vessel filter circulation filter 2161. The first electrodeposition vessel filter circulation filter 2161, which plays the main role in this circulation system, is to remove powder mixed in or generated in the electrodeposition bath. The

10 circulation current amount of the electrodeposition bath of the present circulation system is minutely adjusted mainly with the first electrodeposition vessel filter circulation valve 2166 and subsequently with the first electrodeposition vessel filter circulation pump

15 bypass valve 2158 provided in parallel along the first electrodeposition vessel filter circulation pump 2157. In order to make note of the circulation current amount by these valve adjustment, the first electrodeposition vessel filter circulation pressure gage 2160 is

20 provided. Besides the minute adjustment of the current amount, the first electrodeposition vessel filter circulation pump bypass valve 2158 prevents cavitation from taking place at the time when the filter circulation current amount in its entirety is tightened

25 and damaging the first electrodeposition vessel filter circulation pump 2157.

The electrodeposition bath can be transferred from

a first electrodeposition vessel draining valve 2153 to the first discharging vessel 2172 via the first electrodeposition vessel filter circulation return flange insulation pipe 2152. This transfer is executed
5 at the time of electrodeposition bath exchange, maintenance of the apparatus or emergency. The electrodeposition bath as the transferred waste fluid is caused to drop into the first waste fluid vessel waste fluid storage vessel 2144 by way of gravitational
10 drop. For maintenance or emergency, the first waste fluid vessel waste fluid storage vessel 2144 preferably has a capacity that can store to fulfill at least the total of the bath capacity of the first electrodeposition vessel 2066 and the first circuit
15 vessel 2120. The first waste fluid vessel waste fluid storage vessel upper cap 2277 is installed in the first waste fluid vessel waste fluid storage vessel 2144, and in order to effectuate gravitational dropping transfer of the electrodeposition bath, a first waste fluid
20 vessel air-bleeder 2171 as well as a first waste fluid vessel air vent valve 2170 is provided. The electrodeposition bath temporarily having dropped into the first waste fluid vessel waste fluid storage vessel 2144 loses temperature, and thereafter is brought into
25 waste water treatment at the building side from the first waste fluid vessel waste water valve 2173, or is collected into a now shown drum can via a first waste

liquid vessel waste fluid collection valve 2174, a waster fluid collection origin valve 2175, a waste fluid collection suction filter 2176 and a waste liquid collection pump 2177 so as to be properly disposed.

- 5 Prior to collection or treatment, it is possible that dilution with water and treatment by way of a chemical liquid, etc. are executed inside the first waste fluid vessel waste fluid storage vessel 2144.

10 In order to uniform electrodeposition filming by stirring the electrodeposition bath, air bubbles are arranged to be gushed out from a plurality of orifices pierced in the first electrodeposition vessel stirring air introducing tube 2062 installed in the bottom portion of the first electrodeposition bath holding
15 vessel 2065. The air, which is compressed air supplied to a factor, is taken in from the compressed air introducing orifice 2182, and reaches the first electrodeposition vessel stirring air introducing tube 2062 via an electrodeposition bath stirring compressed
20 air pressure switch 2183, sequentially passing in the direction indicated to the first electrodeposition vessel compressed air introducing direction 2184, a first electrodeposition vessel compressed air origin valve 2185, a first electrodeposition vessel compressed
25 air current amount meter 2186, a first electrodeposition vessel compressed air regulator 2187, a first electrodeposition vessel compressed air mist

separator 2188, a first electrodeposition vessel
compressed air introducing valve 2189, a first
electrodeposition vessel compressed air flexible pipe
2190, a first electrodeposition vessel compressed air
5 insulation pipe 2191, and a first electrodeposition
vessel compressed air upstream side control valve 2193
or a first electrodeposition vessel compressed air
downstream side control valve 2192.

The web conveyed to the second electrodeposition
10 vessel 2116 via the inter-electrodeposition return
roller 2016 undergoes deposition of a second
electrodeposited film or treatment. Variety of usage
of the present apparatus will enable combinations such
as that the second electrodeposited film may be the
15 same as the first electrodeposited film to form one
film with the first electrodeposited film and the
second electrodeposited film, in addition, in spite of
adopting the same quality, may be two-layer lamination
provided with different characteristics (for example,
20 lamination of layers different in particle size for
zinc oxide), or in spite of adopting the same
characteristics, may be two-layer lamination provided
with different quality (for example, lamination of
indium oxide as a transparent electroconductive film
25 and zinc oxide), or may be a lamination of completely
different two layers, and moreover, low oxide is
deposited in the first electrodeposition vessel 2066

while treatment to proceed with oxidation in the second
electrodeposition vessel 2116 is executed, or oxide is
deposited in the first electrodeposition vessel 2066
while corrosive carving treatment in the second
5 electrodeposition 2116 is executed. Accordingly,
conditions on electrodeposition or treatment such as
electrodeposition bath or treatment bath, bath
temperature, bath circulation amount, electric current
density and stirring amount and the like are selected
10 to comply with respective objects. In the case where
time of electrodeposition or treatment for the first
electrodeposition vessel 2066 needs to be different
from those for the second electrodeposition vessel
2116, change in the conveyance time of the web 2006 to
15 be different from that for the second electrodeposition
2116 will do, for the purpose thereof, change in length
of vessel for the first electrodeposition vessel 2066
to be different from that for the second
electrodeposition vessel 2166 is done, or the web is
20 returned for adjustment.

The second electrodeposition vessel 2116 is held
as shown in Fig. 5 in the second electrodeposition bath
holding vessel 2115 that can keep the electrodeposition
bath warm without corrosion against the
25 electrodeposition bath so that the temperature
controlled electrodeposition bath will become the
second electrodeposition bath bath surface 2025. The

position of this bath surface is realized by overflow
by way of a partition provided inside the second
electrodeposition bath holding vessel 2115. The not
shown partition is installed so as to drop the
5 electrodeposition bath to the direction of depth in the
second electrodeposition bath holding vessel 2115 in
its entirety, and the overflowed electrodeposition bath
collected into the second electrodeposition vessel
overflow return orifice 2075 with a gutter structure
10 reaches the second circulation vessel 2222 via the
second electrodeposition vessel overflow return path
2219, and here is heated so as to be returned again to
the second electrodeposition bath holding vessel 2115
from the second electrodeposition vessel upstream
15 circulation nozzle tube 2113 as well as the second
electrodeposition vessel downstream circulation nozzle
tube 2114 to form inflow of electrodeposition bath
sufficient to urge overflow.

The web 2006 passes through an electrodeposition
20 inter-vessel shuttle roller 2016, a second
electrodeposition vessel entry roller 2069, a second
electrodeposition vessel withdrawal roller 2070 and a
pure water shower vessel shuttle entry roller 2279 into
the second electrodeposition vessel 2116. Between the
25 second electrodeposition vessel entry roller 2069 and
the second electrodeposition vessel withdrawal roller
2070, the web surface is present in electrodeposition

bath and faces 28 second electrodeposition vessel
anodes 2076 to 2103. The actual electrodeposition is
carried out by giving negative and positive potentials
to the web and the anodes, respectively, to let an
5 electrodeposition current entailing an electrochemical
reaction flow between them in the electrodeposition
bath.

With the apparatus of Fig. 2, anodes in the second
electro-deposition vessel are placed on seven second
10 electrodeposition vessel anode placement stand 2104 to
2110 four for each (See Fig. 5). Each anode placement
stand is so structured as to take its respective anodes
on it via an insulating plate and is so arranged that a
peculiar potential is applied to it from an independent
15 power supply. Besides, the anode placement stands 2104
to 2110 also function to keep an interval between the
web and the anodes 2076 to 2103 in the
electrodeposition bath. For this purpose, normally, to
maintain a predetermined interval, the anode placement
20 stands 2104 to 2110 are so designed and fabricated as
capable of height adjustment.

The second electrodeposition vessel back face
electrode 2111 provided in direct front of the second
electrodeposition vessel exit roller 2070 serves to
25 electrochemically remove the film deposited on the back
face of the web in the vessel, which purpose is
implemented by setting the second electrodeposition

vessel electrode 2111 to a negative electrode relative to the web as with the first electrodeposition vessel electrode 2061.

To the web coming out through the second
5 electrodeposition vessel withdrawal roller 2070 from the electrodeposition bath, the electrodeposition bath is applied from the electrodeposition vessel outlet shower 2297 and prevents the unevenness from occurring due to the drying of the formed film surface. In
10 addition, a pure water shower vessel shuttle entry roller cover 2318, which is provided at a connecting portion between the second electrodeposition vessel 2116 and the pure water shower vessel 2360, confines the vapor generated from the electrodeposition bath to
15 prevent the formed film surface of the web from being dried. Furthermore, a pure water shower vessel inlet surface pure water shower 2299 and a pure water vessel inlet back face pure water shower 2300 also perform a similar action in addition to washing away the
20 electrodeposition bath.

The second circulation vessel 2222 bears the heating or keeping warmth and current circulation of the electrodeposition bath in the second
electrodeposition vessel 2116. As mentioned above, the
25 electrodeposition bath overflown in the second electrodeposition vessel 2116 is collected to a second electrodeposition vessel overflow return port 2075,

goes along a second electrodeposition vessel overflow
return path 2219, passes through a second
electrodeposition vessel overflow return path
insulating flange 2220 and arrives at a second
5 circulation vessel heating tank 2223. In the second
circulation vessel heating tank 2223, eight second
circulation vessel heaters 2224 to 2234 are provided
and are made to function in initially heating an
electrodeposition at room temperatures or in reheating
10 an electrodeposition bath with a decrease in
temperature by the circulation to retain the electro-
deposition bath to a predetermined temperature.

To the second circulation vessel heating tank
2223, two circulation systems are connected. To be
15 specific, they are a second electrodeposition vessel
upstream circulatory reflux system returning from the
second electrodeposition vessel upstream circulation
jet tube 2113 to the second electro- deposition bath
retention vessel 2115 via a second circulation vessel
20 electrodeposition bath upstream circulation source
valve 2232, a second circulation vessel
electrodeposition bath upstream circulation pump 2234,
a second circulation vessel electro-deposition bath
upstream circulation valve 2237, a second circulation
25 vessel electrodeposition bath upstream circulation
flexible pipe 2238 and a second circulation vessel
electro-deposition bath upstream circulation flange

insulating piping 2239 and a second electrodeposition vessel downstream circulation reflex system returning from the second electro-deposition vessel downstream circulation jet tube 2114 to the second

5 electrodeposition bath retention vessel 2115 via a second circulation vessel electrodeposition bath downstream circulation source valve 2242, a second circulation vessel electrodeposition bath downstream circulation pump 2245, second circulation vessel

10 electrodeposition bath downstream circulation valve 2247, a second circulation vessel electrodeposition bath downstream circulation flexible pipe 2248 and a second circulation vessel electrodeposition bath downstream circulation flange insulating piping 2249.

15 The electrodeposition bath returning from the second electrodeposition vessel upstream circulation jet tube 2113 and the second electrodeposition vessel downstream circulation jet tube 2114 to the second electrodeposition vessel 2116 is refluxed from the

20 second electrodeposition vessel upstream circulation jet tube 2113 and the second electro-deposition vessel downstream circulation jet tube 2114 provided below the second electrodeposition bath retention vessel 2115 via orifices bored in their respective jet tubes as a jet.

25 Reflux quantities in individual circulatory reflux systems are principally controlled by the opening of the second circulation vessel electrodeposition bath

upstream circulation valve 2237 or the second
circulation vessel electrodeposition bath downstream
circulation valve 2247 and a finer adjustment is
controlled by a second circulation vessel
5 electrodeposition bath upstream circulation pump bypass
valve 2235 or a second circulation vessel
electrodeposition bath downstream circulation pump
bypass valve 2244 provided at a bypass system shorting
and connecting the outlet and the inlet of the second
10 circulation vessel electrodeposition bath upstream
circulation pump 2234 or the second circulation vessel
electrodeposition bath downstream circulation pump
2245. The bypass system also serves to prevent the
cavitation in a pump in case of a reduced reflux
15 quantity or at the extremely vicinity of the bath
temperature to its boiling point. As described also in
the description of a first electrodeposition bath, the
cavitation that boiling and evaporation of a bath
liquid prevents the infeed of the liquid significantly
20 shortens the service life of the pump.

In case of boring orifices in the second
electrodeposition vessel upstream circulation jet tube
2113 and the second electro-deposition vessel
downstream circulation jet tube 2114 to form a jet, the
25 reflux quantity is determined almost by the pressure of
the bath liquid returned to the second
electrodeposition vessel upstream circulation jet tube

2113 and the second electro-deposition vessel downstream circulation jet tube 2114. A second electrodeposition vessel upstream circulation pressure gauge 2236 and a second electro-deposition vessel downstream circulation pressure gauge 2246 are provided to sense this pressure and the balance of a reflux quantity can be learned by means of these pressure gauges. Though conforming to the Bernouilli's theorem, the quantity of the reflux liquid spouted from an orifice can be made substantially constant entirely over the second electrodeposition vessel upstream circulation jet tube 2113 or the second electro-deposition vessel downstream circulation jet tube 2114 if the orifice bored in a jet tube is not greater than several millimeters in diameter. Furthermore, when the reflux quantity is sufficiently large, the exchange of a bath is very smoothly performed and accordingly a uniformed concentration and a uniformed temperature of a bath can be effectively achieved even if the second electrodeposition vessel 2116 is considerably long. Rightfully, the second electrodeposition overflow return path 2219 should be broad enough to allow this sufficient reflux quantity to flow.

The second circulation vessel electrodeposition bath upstream circulation flexible pipe 2238 and second circulation vessel electrodeposition bath downstream circulation flexible pipe 2248 provided at individual

circulatory reflux systems serve to absorb strains of the respective piping systems and in particular effective for the case of using a flange insulating piping or the like in which the mechanical strength is often insufficient for a strain. The second circulation vessel electrodeposition bath upstream circulation flange insulating piping 2239 and second circulation vessel electrodeposition bath downstream circulation flange insulating piping 2249 provided at individual circulatory reflux systems serve to electrically float the second circulation vessel 2222 and the second electrodeposition vessel 2116 together with the second electrodeposition vessel overflow return path insulating flange 2220 provided midway in the second electrodeposition vessel overflow return path 2219. This is based on findings of the present inventors that eliminating the formation of an unnecessary current route prevents a stray current, thereby leading to using most of the electrodeposition current for an electrochemical film formation reaction.

Provided in a one-side circulatory reflux system is a bypass system directly returning to the second circulation vessel heating tank 2223 comprising a second circulation vessel electrodeposition bath bypass circulation flexible pipe 2250 and a second circulation vessel electrodeposition bath bypass circulation valve

2251, which is used in the case where circulation of a bath liquid is desired without reflux of the bath liquid to the second electrodeposition vessel, as is common, e.g. at the temperature elevation from room
5 temperatures to a predetermined temperature. Besides, provided in both circulatory reflux systems from the second circulation vessel are two liquid feed systems comprising one feed to a second electrodeposition vessel inlet shower 2068 for applying an
10 electrodeposition bath to a web directly before the second electrodeposition vessel entry roller 2069 and the other feed to second electrodeposition vessel outlet shower 2297 for applying an electrodeposition bath to the web leaving the electro- deposition vessel
15 after passing through the second electro-deposition vessel withdrawal roller 2070. The former is linked to the second electrodeposition vessel inlet shower 2068 via the second electrodeposition vessel inlet shower valve 2241 and the latter is linked to the second
20 electrodeposition vessel outlet shower 2297 via the second electrodeposition vessel outlet shower valve 2252. The spray amount of an electrodeposition liquid from the second electrodeposition vessel inlet shower 2068 is regulated by adjusting the opening of the
25 second electrodeposition vessel inlet shower valve 2241, whereas that of an electrodeposition liquid from the second electrodeposition vessel outlet shower 2297

is regulated by adjusting the opening of the second electrodeposition vessel outlet shower valve 2252.

The second circulation vessel heating tank 2223, in practice, equipped with a lid, is so structured as
5 to prevent water from being lost into a vapor. For a high bath temperature, the temperature of the lid also becomes high and consequently consideration of gluing a heat insulator or the like is necessary from the viewpoint of operation safety.

10 To remove the powder of the second electrodeposition vessel electrodeposition bath, a filter circulatory system is provided. The filter circulatory system for the second electrodeposition vessel comprises a second electrodeposition vessel
15 filter circulation return flexible pipe 2253, a second electrodeposition vessel filter circulation return flange insulating piping 2253, a second electrodeposition vessel filter circulation source valve 2256, a second electrodeposition vessel filter
20 circulation suction filter 2258, a second electrodeposition vessel filter circulating pump 2260, a second electrodeposition vessel filter circulating pump bypass valve 2259, a second electrodeposition vessel filter circulation pressure switch 2261, a
25 second electrodeposition vessel filter circulation pressure gauge 2262, a second electrodeposition vessel filter circulating filter 2263, a second

electrodeposition vessel filter circulation flexible
pipe 2266, a second electrodeposition vessel filter
circulation flange insulating piping 2267, a second
electrodeposition vessel filter circulation valve 2268,
5 a second electrodeposition vessel filter circulatory
system electrodeposition bath midstream return valve
2270 and a second electrodeposition vessel filter
circulatory system electrodeposition bath downstream
return valve 2271. Along this route, the
10 electrodeposition flows in the filter circulating
directions 2257, 2264 and 2265 of the second
electrodeposition vessel. The powder to be removed
might jump in from outside the apparatus or might be
formed on the surface of an electrode or in the bath.
15 The minimum size of the powder to be removed is
determined by the filter size of the second
electrodeposition vessel filter circulating filter
2263.

The second electrodeposition vessel filter
20 circulating filter circulation return flexible pipe
2253 and the second electro-deposition vessel filter
circulation flexible pipe 2266 does not only absorb the
distortion of piping to minimize the liquid leakage
from the piping connection part but also protects the
25 insulating piping having low mechanical strength to
raise the disposing freedom of constituent components
of the circulatory system beginning with a pump. To

prevent the second electrodeposition bath retention vessel 2115 floating apart from the ground connection from falling to the ground connection, the second electrodeposition vessel filter circulation return
5 flange insulating piping 2254 and the second electrodeposition vessel filter circulation flange insulating piping 2267 is provided for its electrical flotation. The second electro-deposition vessel filter circulation suction filter 2258 is a wire gauze like
10 so-called "tea filter", serving to remove a large trash and protect the second electrodeposition vessel filter circulating pump 2260 and the second electrodeposition vessel filter circulating filter 2263 subsequent thereto. The second electrodeposition vessel filter
15 circulating filter 2263 plays the principal part and serves to remove the powder mixed and generated in the electrodeposition bath. The circulation flow rate of the electrodeposition bath of this circulatory system is finely regulated principally by means of the second
20 electro-deposition vessel filter circulation valve 2268 and supplementally by means of the second electrodeposition vessel filter circulation pump bypass valve 2259 provided in parallel with the second electrodeposition vessel filter circulating pump 2260.
25 To grasp the circulation flow rate by these valve regulation, a second electrodeposition vessel filter circulation pressure gauge 2262 is provided. In

addition to the fine regulation of the flow rate, the second electrodeposition vessel filter circulating pump bypass valve 2259 prevent occurrence of cavitation from damaging the second electrodeposition vessel filter circulating pump 2260 in case of reducing the whole flow rate of filter circulation.

The electrodeposition bath can be transported from second electrodeposition vessel drain valve 2255 to the second exhaust liquid 2274 via the second electrodeposition vessel filter circulation return flange insulating piping 2254. This transfer is carried out in the exchange of an electrodeposition bath, the maintenance of an apparatus and further an emergency. The electrodeposition bath regarded as the exhaust liquid to be transferred is dropped to a second exhaust liquid vessel exhaust liquid tank 2273 by the gravitational falling. For the purpose of maintenance and emergency, the second exhaust liquid vessel exhaust liquid tank 2273 preferably has a capacity for storing the sum of the liquid capacities of a second electrodeposition vessel 2116 and a second circulation vessel 2222. At the second exhaust liquid vessel exhaust liquid tank 2273, a second exhaust liquid vessel exhaust liquid tank upper lid 2278 is provided and a second exhaust liquid vessel air vent 2276 and a second exhaust liquid vessel air vent valve 2275 are provided to make the gravitational falling transport of

an electrodeposition bath effective. After the bath temperature falls, the electrodeposition bath dropped once to the second exhaust liquid vessel exhaust tank 2273 is subjected to the waste water treatment at the building side from the second exhaust liquid vessel drain valve 2180 or collected into an unillustrated drum can via a second exhaust liquid vessel exhaust liquid collection valve 2181, an exhaust liquid collection source valve 2175, an exhaust liquid collection suction filter 2176 and an exhaust liquid collection pump 2177 and subjected to a proper disposal. Prior to the collection or the treatment, dilution with water, treatment with a medicament or the like may be performable in the second exhaust liquid vessel exhaust liquid tank 2273.

To agitate an electrodeposition so as to make uniform an electrodeposition, air bubbles are so arranged as to jet out from multiple orifices bored in the second electrodeposition vessel agitating air introduction tube 2112 provided at the bottom of the second electrodeposition bath retention vessel 2115. As the air, compressed air is taken from a compressed-air introducing port 2182, delivered via an electrodeposition bath agitating compressed air pressure switch 2183 in the direction indicated by the arrowhead of second electrodeposition vessel compressed air introducing direction 2194 and passes through a

second electrodeposition vessel compressed air source
valve 2195, a second electrodeposition vessel
compressed air flow meter 2196, a second
electrodeposition vessel compressed air regulator 2197,
5 a second electrodeposition vessel compressed air mist
separator 2198, a second electrodeposition vessel
compressed air introducing valve 2199, a second
electrodeposition vessel compressed air flexible pipe
2220, a second electrodeposition vessel compressed air
10 insulating piping 2201 and a second electrodeposition
vessel compressed air upstream-side control valve 2202
or a second electrodeposition vessel compressed air
downstream-side control valve 2272 in sequence to the
second electrodeposition vessel agitating air
15 introduction tube 2112.

At the first electrodeposition vessel 2066 or the
second electro-deposition vessel 2116, a reserve
introduction system is provided so that a reserve
liquid or air can be introduced. The liquid or air
20 from an electrodeposition vessel reserve introducing
port 2213 is introduced via an electrodeposition vessel
reserve introducing valve 2214 and through a first
electrodeposition vessel reserve introducing valve 2215
and a first electro- deposition vessel reserve
25 introduction insulating piping 2216 to the first
electrodeposition vessel and further introduced through
a first electrodeposition vessel reserve introducing

valve 2217 and a second electrodeposition vessel reserve introducing valve 2218 to the second electrodeposition vessel. The most possible substance introduced in the reserve introduction system is a
5 retaining agent or a supplementary agent for keeping the capability of a bath constant for a long time, may be an air dissolved into the bath or an acid for removing the powder in some case.

Washing is carried out at the three stages
10 comprising a pure water shower vessel, a first warm water vessel and a second warm water vessel. The arrangement of washing is such that the pure water warmed is supplied to the second warm water vessel, its exhaust liquid is used in the first warm water vessel
15 and further its exhaust water is used in the pure water shower vessel. By this, a web is gradually washed with a higher purity water after the completion of electrodeposition in an electrodeposition vessel.

The second warm water vessel uses the purest pure
20 water. This pure water is supplied to a second warm water vessel outlet back face pure water shower 2309 and a second warm water vessel outlet surface pure surface shower 2310 directly before the withdrawal of the web. The pure water to be supplied is delivered
25 from a water washing system pure water port 2337 through a water washing system pure water supply source 2338, stored once in a pure water heating vessel 2339,

warmed to a predetermined temperature by pure water heating vessel pure water heating heaters 2340 to 2343, passes through a pure water heating vessel pure water delivery valve 2344, a pure water heating vessel
5 delivery pump 2346, a pure water heating vessel pressure switch 2347, a pure water heating vessel cartridge-type filter 2349 and a pure water heating vessel flow meter 2350, then partly delivered from a second warm water vessel outlet back face shower valve
10 2351 to a second warm water vessel outlet back face shower 2309 and the rest is delivered from a second warm water vessel outlet surface shower valve 2352 to a second warm water vessel outlet surface shower 2310. Warming is made to promote the cleaning effect. The
15 pure water supplied to the shower and accumulated in the second warm water vessel retaining vessel 2317 forms a pure water rinse bath, in which the web is washed with still water. To keep the temperature of the pure water from declining, a second warm water
20 vessel warm water temperature-retaining heater 2307 is provided at the second warm water vessel.

To the first warm water vessel 2361, the pure water overflowed from the second warm water vessel retaining vessel 2317 is supplied from the second warm
25 water vessel 2362 via the linking tube 2232 between the warm water vessels. As with the second warm water vessel 2262, a first warm water vessel warm water

temperature-retaining heater 2304 is provided so as to retain the temperature of the pure water r.

Furthermore, at the first warm water vessel 2361, an ultrasonic wave source 2306 is provided so as to

5 positively remove the stain of the web back face between the first warm water vessel roller 2282 and the second warm water vessel shuttle entry roller 2283.

Subsequent to the pure water shower vessel pure water shower supply source valve 2323, the pure water
10 from the first warm water vessel retaining vessel 2316 is delivered through a pure water shower vessel pure water shower supply pump 2325, a pure water shower vessel pure water shower supply pressure switch 2326, a
15 cartridge-type filter 2328 and a pure water shower vessel pure water shower supply flow meter 2329, then from a pure water shower vessel inlet surface pure water shower valve 2330 to a pure water shower vessel inlet surface pure water shower 2299, from a pure water
20 shower vessel inlet back face pure water shower valve 2331 to a pure water shower vessel inlet back face pure water shower 2300, from a pure water shower vessel outlet back face pure water shower valve 2332 to a pure water shower vessel outlet back face pure water shower
25 2302, from a pure water shower vessel outlet surface pure water shower valve 2333 to a pure water shower vessel outlet surface pure water shower 2303, while

cleaning shower flows are applied to the web surface and the web back face respectively at the inlet and the outlet of the pure water shower vessel 2360. The water having finished showering is received by a pure water shower vessel receiver vessel 2315, joins part of the first warm water vessel warm water retaining vessel 2316 and a second warm water vessel warm water retaining vessel 2317 and is discarded to the water washing system drainage 2336. Normally, since ions or others are contained in the cleaning finished water, a given treatment is required.

In the pure water shower vessel 2360, the first warm water vessel 2361 and the second warm water vessel 2362 for the cleaning, a web is delivered through the pure water shower vessel shuttle entry roller 2279, the pure water shower vessel roller 2280, the first warm water vessel shuttle entry roller 2281, the first warm water vessel roller 2282, the second warm water vessel shuttle entry roller 2283 and the second warm water vessel roller 2284 to the dry shuttle roller 2285. Directly after the pure water shower vessel shuttle entry roller 2279, a pure water shower vessel back face brush 2298 is provided so as to remove the relatively large grain-size powder adhered to the web back face and products weak in adhesive force.

First at the inlet of the drying section, the web having arrived at the drying section 2363 is dehydrated

by means a drying section inlet back face air knife 2311 and a drying section inlet back face air knife 2312. Introduction of air into the air knife is carried out in a route comprising a drying system

5 compressed air introducing port 2353, a drying system compressed air pressure switch 2354, a drying system compressed air filter regulator 2355, a drying system compressed air mist separator 2356 and a drying system compressed air supply valve 2357 followed by a drying

10 section inlet back face air knife valve 2358 or a drying section inlet back face air knife valve 2359. Since especially the water content of the air supplied to the drying section is unfavorable, the role of the drying system compressed air mist separator 2356 is

15 important.

In the subsequent step of the web transported from the dry shuttle roller 2285 to the wind-up apparatus entry roller 2286, drying by means of radiation heat of lining-up IR lamps 2313 is performed. If the radiation

20 heat of IR lamps is sufficient, no unfavorable effect is caused even if an electrodeposition film is cast into a vacuum device such as CVD device. During the drying, generation of a mist due to the dehydration and generation of a water vapor by the IR lamp radiation

25 takes place and the drying section vent 2314 linked with the exhaust duct is indispensable. The water vapor collected in the drying exhaust duct 2370 mostly

returns to liquid water at the drying system condenser 2371 and is discarded to a drying system condenser exhaust water drain 2373 and partly to a drying system exhaust air 2374. If a harmful gas is contained in
5 water vapor, the exhaust air should be subjected to a given treatment.

Through the wind-up apparatus entry roller 2286, a wind-up apparatus direction conversion roller 2287 and a wind-up regulating roller 2288 in sequence, the wind-
10 up apparatus 2296 winds up the web 2006 on a web winding bobbin 2289 in the shape of a coil. If protection of the deposited layer is necessary, an interleaf is drawn out from an interleaf draw-out bobbin 2290 and wound into the web as shown in Fig. 7.
15 The conveying direction of the web 2006 is indicated by Arrowhead 2292, the rotating direction of the web winding bobbin 2289 is indicated by Arrowhead 2293 and the wind-up direction of the interleaf draw-out bobbin 2289 is indicated by Arrowhead 2294. In Fig. 7, it is
20 shown that no interference occurs between the web wound up on the web winding bobbin 2289 and the interleaf drawn out from the interleaf draw-out bobbin 2290 respectively at the position of conveyance start and that of conveyance end. For the purpose of dust guard,
25 the whole wind-up apparatus is so structured as to be covered with a wind-up apparatus clean booth 2295 using a HEPA filter and a down flow.

With the apparatus shown in Fig. 7, a function of correcting the meander of a web is afforded to the wind-up apparatus direction converting roller 2287. In response to a signal from a meander detector provided
5 between the wind-up apparatus direction converting roller 2287 and the wind-up regulating roller 2288, the wind-up apparatus direction converting roller 2287 is swung around the pivot axis set at the side of the wind-up apparatus entry roller 2286 by an hydraulic
10 servo, thereby enabling the correction of a meander. In Fig. 7, the control of the wind-up apparatus direction converting roller 2287 is approximately the move of the roller to this side or to the inner side, whose direction is opposed to the direction of web
15 meander detected from the meander detector. The gain of a servo depends on the conveying rate of a web, but is generally not required to be large. Even when winding up a several hundred meter long web, its end face can be aligned at a precision of sub-millimeter.
20 The pivot axis actually employed is 2 m long to the web upstream side and is 2 m or longer toward the rollers before and behind the wind-up apparatus direction converting roller 2287, so that no ear wave occurs even
25 within the width of several mm. This becomes apparent by the analysis mentioned above. Besides, use of a reflection type laser position detector for the meander

detection is favorable from the viewpoint of precision.

Use of an electrodeposition bath or warm water at a higher temperature than room temperatures necessarily results in generation of a water vapor. Especially, if the used temperature exceeds 80°C, occurrence of a vapor becomes considerable. The water vapor generated from the bath surface of a vessel is accumulated on the bath surface and blows off forcefully from a gap of the apparatus, emits in a great amount at the opening or closing of a lid or flows down in water droplets from a gap of the apparatus, thus worsening the manipulating environments of the apparatus. Thus, it is advisable to forcibly suck and exhaust the water vapor via an exhaust duct. Exhaust ports linked with such exhaust ducts include a first electrodeposition vessel upstream exhaust port 2021, a first electrodeposition vessel midstream exhaust port 2022 and a first electrodeposition vessel downstream exhaust port 2023 of the first electrodeposition vessel 2066, a second electrodeposition vessel upstream exhaust port 2071, a second electrodeposition vessel midstream exhaust port 2072 and a second electrodeposition vessel downstream exhaust port 2073 of the second electrodeposition vessel 2116, a pure water shower vessel exhaust port 2301 of the pure water shower vessel 2360, a first warm water vessel exhaust port 2305 of the first warm water vessel 2361 and a second warm water vessel exhaust port

2308 of the second warm water vessel 2308. The water vapor collected at an electrodeposition vessel system and water washing vessel system exhaust duct 2020 passes through an insulating flange, mostly returns to liquid water at an electrodeposition water washing system exhaust duct condenser 2366 and is discarded to an electrodeposition water washing system exhaust duct condenser exhaust water drain 2368 and partly to an electrodeposition water washing system exhaust air 2369. If a harmful gas is contained in water vapor, the exhaust air should be subjected to a given treatment.

With the apparatus shown in Fig. 2, since the exhaust duct was made of a stainless steel, an electrodeposition water washing system exhaust duct trunk insulating flange 2365 and an electrodeposition water washing system exhaust duct water washing side insulating flange 2364 were provided to keep the first electrodeposition bath retaining vessel 2065 of the first electrodeposition bath 2066 and the second electrodeposition bath retaining vessel 2115 of the second electrodeposition bath 2116 at a float potential apart from the ground connection, so that the exhaust ducts were electrically separated from both retaining vessels.

When this apparatus was used to form an oxide on the web, however, the following inconveniences were

revealed to present in the conveying system. Namely, where a meander correcting system with the web upstream side taken as the pivot was incorporated into the wind-up apparatus direction converting roller 2287 in Fig.

5 7, the conveyance route was almost constant without any meander and the web was wound on the web winding bobbin 2289 with the ends exactly aligned in a condition of room temperatures. Nevertheless, when the conveyance was performed with the electrodeposition bath set to a
10 given temperature, e.g. 85°C, indeed, a web was wound on the web winding bobbin 2289 with the ends exactly aligned, but a ripple-shaped permanent deformation, or commonly-called ear wave deformation occurs on the wound web. No counter-measure was discussed about such
15 an ear wave was discussed in the above publicly-known example or no countermeasure against this was taken.

As a result of examinations by the present inventors, this was found to be because in individual conveying rollers made in parallel with each other
20 during room temperatures, the struts supporting an electrodeposition vessel underwent thermal deformation due to heating of the relevant electrodeposition bath and further the roller axes supported and retained by them slipped out of place. Although the capability of
25 the winding apparatus direction converting roller 2287, into which a meander correcting system with the web upstream side taken as the pivot was incorporated, was

sufficient and the end surface correction was accomplished, yet a partial deformation exceeding the yield stress led to occurrence of an ear wave.

According to Japanese Patent Application Laid-Open
5 No. 10-194540 (Steering Apparatus and Steering Method
of Strip; Sumitomo Metal, Ltd.; published on July 28,
1998), a pivot and its inclination is controlled to
accomplish the meander correction only by the turn roll
without use of an auxiliary roll and the occurrence of
10 an ear wave can be prevented by controlling both of
them. This is based on an idea that pivoting a turn
roll is inevitable to produce too long and too short
routes on both sides of a web and accordingly the
difference between too long and too short routes is
15 minimized by a simultaneous inclination control for
correcting their difference so as to prevent the
occurrence of an ear wave. Since the ear wave put in a
problem by the present inventors has already occurred
apart from the correcting roller, this invention is not
20 applicable.

Besides, after examinations were made using the
apparatus shown in Fig. 2, the following inconveniences
were revealed. That is, part of the film deposited on
a long-scaled substrate was thinner, higher in electric
25 resistance or generated a greater amount of microscopic
protrusions due to abnormal growth than the other and
such a portion was difficult to use as the optical

confinement reflecting layer.

As a result of repeated examinations by the present inventors, it was confirmed that occurrence of such inconveniences originated in the non-
5 uniformity/instability of electric current. And, causes for bringing about the non-uniformity/instability of electric current were found to lie in a poor current supply to a long-scaled substrate from a feeder roller, in other words, the
10 non-uniformity in connection or butt between a feeder roller and a long-scaled substrate.

SUMMARY OF THE INVENTION

Hence, in consideration of the above described
15 problem, an object of the present invention is to provide a web conveying apparatus capable of, in formation of a functional film, conveying a web, which is treated by winding in a coil shape, without occurrence of an ear wave in a predetermined speed and
20 keeping a distance from an opposite electrode for film formation without snaking. Specifically, an electrodeposition apparatus formable at low cost does not require a rigid chamber like that of a vacuum film formation apparatus. Therefore, a part supporting a
25 roller is adapted to be deformed by a temperature and a tension. In this case, supplying an enough conveying apparatus is important.

Another object, in consideration of the above described problem, of the present invention is to provide a continuous electrodeposition apparatus and a continuous electrodeposition method, for an oxide film, capable of flowing an even and stable electrodeposition current to electrodeposit continuously an even zinc oxide film on an elongated substrate.

Subsequently, the present invention provides a web conveying apparatus for holding and conveying a web while applying tension to the web, wherein the conveying apparatus has a plurality of rollers conveyed by contacting with the web and a mechanism for limiting deformation of the web to Y/E or smaller by at least one of the rollers, where Y is yield strength of the web and E is Young's modulus of the web.

A preferable embodiment of such web conveying apparatus exemplified by the above described mechanism is a mechanism for controlling inclination of an axis of the roller having the mechanism.

In addition, one having a snaking-correction mechanism to correct snaking of the above described web and one, in which the snaking-correction mechanism comprising a displacement detection signal generating device using a laser sensor and an arc motion roller for giving a motion in direction opposite to displacement to the above described web on the basis of the displacement detection signal, are also preferable.

Further, one in which the mechanism for controlling inclination of the axis of the above described roller is a mechanism for controlling inclination of the axis by vertically moving one end of the axis and using the other end of the axis as a fulcrum, one having a inclination detection mechanism employing a noncontact sensor, one having the servo-moving mechanism having a plurality of discrete control amounts, one having the servo-moving mechanism with a continuous control amount, and one having the servo-moving mechanism and a mechanism for preventing a maximum control amount due to the servo-moving mechanism from exceeding yield stress of edges of the web are all exemplified as preferable implementations.

One having mechanism for controlling tension applied to the above described web to 0.49 N or more per 1-cm web width, and one for keeping difference between inclination of the axis of the roller having the above described mechanism for controlling the inclination of the axis of the above described roller and inclination of the axes of preceding and succeeding rollers to 1.025/1000 radian or smaller are also preferable. It is further preferable that the roller having the mechanism to control inclination of the axis of the above described roller is an electrical supply roller.

Furthermore, the present invention provides the

electrodeposition apparatus having the above described web conveying apparatus, an electrodeposition vessel to hold an electrodeposition bath in which electrodeposition is carried out by dipping the web, and an electrode for electrodeposition.

In addition, the present invention provides the web conveying method using the electrodeposition apparatus to hold the web and convey by applying tension to the web, wherein the electrodeposition apparatus has a plurality of rollers to be conveyed by contacting with the web and carries out conveyance by suppressing deformation in a range of Y/E or less by the mechanism installed in at least one roller of the rollers.

It is preferable in such conveying method that inclination of the axis of the roller having the mechanism is suppressed by the above described mechanism.

Besides, it is preferable that conveyance is carried out by correcting snaking of the above described web by the snaking-correction mechanism and more preferable that the above described snaking-correction mechanism has the displacement detection signal generating apparatus using the laser sensor and the arc motion roller to move the arc motion roller and give the motion in direction opposite to displacement to the above described web on the basis of the

displacement detection signal, are more preferable.

Further, it is also preferable implement that by the mechanism to control inclination of the axis of the above described roller, conveyance is carried out by moving the one end vertically using the other end, as the fulcrum, of the axis of the roller. It is also preferable implement that the mechanism to control inclination of the axis of the above described roller has the inclination detection mechanism employing the noncontact sensor and conveyance is carried out through monitoring inclination of the axis by the detection mechanism, the mechanism to control inclination of the axis of the above described roller has the servo-moving mechanism and the mechanism to control the maximum control amount by the servo-moving mechanism to suppress in a range of not more than the yield stress of the edges of the web are all exemplified as preferable implementations and conveyance is carried out by controlling deformation of the web to suppress in a range of not more than the yield stress of the edges of the web by these mechanisms, conveyance is carried out controlling tension applied to the above described web in a range of 0.49 N or higher per 1-cm web width, conveyance is carried out keeping the distance between inclination of the axis of the roller having the mechanism to control inclination of the above described axis of the above described roller and

inclination of the axis of rollers before and after the roller to 1.025/1000 radian or smaller, and conveyance is carried out controlling inclination of the axis of the electrical supply roller by the mechanism to
5 control inclination of the axis of the above described roller.

Furthermore, the present invention provides the electrodeposition method characterized in that the web is conveyed to pass through the electrodeposition bath
10 by the above described web conveying method and a film is formed on the web by electrodeposition.

Another embodiment of the web-conveying apparatus provided by the present invention is that the web-conveying apparatus comprising a wind-up roller for
15 giving a driving force for conveying in a predetermined speed the web to treat by winding in the coil form and for winding up a treated web by arranging the end thereof, a delivery roller (wind-off roller) for continuously delivering the web while holding an
20 untreated web and applying tension to the web between the delivery roller the wind-up roller, a plurality of follower rollers for changing a travelling direction of the web, which is conveyed in a predetermined speed while the tension is kept by the wind-up roller and the
25 delivery roller, according to treatment of the web, and a snaking-correction means for winding up the web by arranging the end thereof by the wind-up roller,

wherein at least one roller of a plurality of the above described follower rollers has means for suppressing the web deformation amount caused by roller axes in a range of Y/E or less, where Y is yield strength of the web and E is Young's modulus of the web. Similar to such means, an axis inclination-controlling means to control inclination of the axis of the roller is preferable.

In the above described web conveying apparatus, it is preferable that the snaking-correction means of the web comprises the displacement detection signal generating apparatus using the laser sensor and the arc motion roller to give the motion in the direction opposite to displacement to the web on the basis of the displacement detection signal.

It is also preferable that the above described axis inclination-controlling means is the means to control inclination of the axis of the roller by moving the one end vertically using the other end, as the fulcrum, of the roller axis of the follower roller.

In addition, it is preferable that the above described axis inclination-controlling means comprises inclination detection means employing the noncontact sensor and servo-moving means having a plurality of the discrete control amount.

Or, it is preferable that the above described axis inclination-controlling means comprises inclination

detection means employing the noncontact sensor and the servo-moving means having a continuous control amount.

And, it is preferable that the maximum control amount by the above described servo-moving means does
5 not exceed the yield stress of the edges of the web.

Furthermore, the present invention provides the electrodeposition apparatus having such the web-conveying apparatus.

Another continuous electrodeposition apparatus
10 provided by the present invention is a continuous electrodeposition apparatus in which a current is applied between a web (elongated substrate) soaked in an electrodeposition bath and an anode to deposit continuously electrochemically a film on the elongated
15 substrate, wherein a tension is applied to the elongated substrate and the elongated substrate is conveyed by winding a part thereof around an electrical supply roller, which feeds or receives all currents for electrodeposition through a feeding means, wherein
20 inclination between the axis of the electrical supply roller and the axes of preceding and succeeding rollers during conveyance thereof is kept to a predetermined angle or smaller which is determined based on a ratio the yield strength to Young's modulus of the elongated
25 substrate.

It is preferable in the above described continuous electrodeposition apparatus for the oxide film that

tension applied to the elongated substrate is 0.49 N or more per 1-cm width of the substrate.

It is preferable that inclination between the axis of the electrical supply roller and the axes of preceding and succeeding rollers is kept to 1.025/1000 radian or smaller.

In addition, the oxide film is preferably a zinc oxide film deposited in the electrodeposition bath containing at least a nitrate ion and a zinc ion.

The elongated substrate is preferably a metal substrate.

On the other hand, in the continuous electrodeposition apparatus for an oxide film according to the present invention, an elongated substrate to be conveyed and an anode opposite thereto are soaked in an electrodeposition bath, and a current is applied between the elongated substrate and the anode to deposit continuously an oxide film electrochemically on the elongated substrate, wherein a tension is applied to the elongated substrate, and the elongated substrate is conveyed by winding a part thereof around an electrical supply roller, which feeds or receives all currents for electrodeposition through a feeding means, and inclination between the axis of the electrical supply roller and the axes of preceding and succeeding rollers during conveyance thereof is kept to a predetermined angle or smaller which is determined

based on the ratio of the yield strength to Young's modulus of the elongated substrate.

It is preferable in the above described continuous electrodeposition apparatus for the oxide film that
5 tension applied to the elongated substrate is 0.49 N or more per 1-cm width of the substrate.

It is preferable that inclination between the axis of the electrical supply roller and the axes of preceding and succeeding rollers is kept to 1.025/1000
10 radian or smaller.

The oxide film is preferably a zinc oxide film deposited in the electrodeposition bath containing at least nitrate ions and zinc ions.

And, as the elongated substrate, using a metal
15 substrate is preferable.

These preferable implementations are, needless to say, can be applied in combination under a condition not contradicted each other.

20 BRIEF DESCRIPTION OF THE DRAWINGS

Figs. 1A, 1B, and 1C are schematic diagrams showing a relation between the web to be conveyed and the follower roller;

Fig. 2 is the schematic diagrams showing an
25 example of the electrodeposition apparatus applicable of the present invention;

Fig. 3 is the schematic diagrams showing a wind-

off apparatus in the electrodeposition apparatus
applicable of the present invention;

Fig. 4 is the schematic diagrams showing a first
circulation vessel in the electrodeposition apparatus
5 applicable of the present invention;

Fig. 5 is the schematic diagrams showing a second
circulation vessel in the electrodeposition apparatus
applicable of the present invention;

Fig. 6 is the schematic diagrams showing a first
10 liquid exhaust vessel and a second liquid exhaust
vessel in the electrodeposition apparatus applicable of
the present invention;

Fig. 7 is the schematic diagrams showing a pure
water shower vessel, a first warm water vessel, a
15 second warm water vessel, a drying apparatus, and wind-
up apparatus in the electrodeposition apparatus
applicable of the present invention;

Fig. 8 is the schematic diagrams showing a pure
water-heating vessel and the like in the
20 electrodeposition apparatus applicable of the present
invention;

Fig. 9 is the schematic diagrams showing a water
exhaust system in the electrodeposition apparatus
applicable of the present invention;

Fig. 10 is the schematic diagrams showing the
25 example of the roller axis inclination-controlling
means according to the present invention;

Fig. 11 is a graphical illustration showing the example of servo feedback of the axis inclination-controlling means according to the present invention; and

5 Fig. 12 is a schematically cross-sectional view of a solar cell having the oxide film fabricated according to the present invention.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

10 The inventors conducted the following examinations for creating the present invention.

Fig. 1A shows an attitude when the axis of the roller has tilted for δ made by proceeding of the web 1006 with the width w , which has wound around the
15 roller. A point C is a immobile point being such as the roller immediately before. Where, in the Fig 1B showing a extended web, a side, where the roller is lifted, namely, a front side delays for $d = w \tan \delta \cdot \sin \theta$ and therefore, the progressing direction P of the web
20 1006 tilts for β . If no friction is assumed between the roller and the web 1006, the progressing direction of the web 1006, tilted causes shift of the web conveyed in the speed vd/w [mm/min] (to the front in this case) on the roller. On the other hand, as shown
25 in the Fig. 1C, in the case where the roller axis tilts as s , treatment similar to motion like d is possible.

The above described analysis shows that in the case where the roller axis is tilted by influence of heat and tension, conveyance of the web 1006 may move to a different direction and then, that positively
5 tilting the roller axis allows correction of the conveying web 1006 snaking.

By the way, inclination of the roller axis must not be limitlessly large. Excessively large angle causes, as readily presumable, large tension
10 deformation causes in the web and thus, the edge exceeds the yield strength to cause permanent deformation. This phenomenon is so-called ear wave. As a result of examination by the inventors, no ear wave occurs under the following condition: for 1
15 roller, if it is assumed that a distance from the roller immediately before is L_1 and the distance up to the roller immediately after is L_2 , and the Young's modulus is E and the yield strength of a web material is Y , the web deformation becomes $d/(L_1 + L_2)$ and

20
$$Y/E \geq d/(L_1 + L_2)$$

is held. This relation is same in lateral inclination of the roller axis. A left side is determined by material and shape of the web. On the other hand, the distance between rollers is determined at designing the
25 apparatus. In other words, determination of the web and determination of the distance between rollers subsequently determine tolerance of deviation between

roller axes. On the contrary, in order to allow deviation, the distance between rollers should be previously set to a large value. If allowable, it is possible to select an effective shape and material of the web after building up a film-forming apparatus.

If the distance between rollers can be set to the large one, or if deformation of the web can be reduced by decreasing tension applied to the web, the above requirement is relaxed. In addition, in the case where the web itself has elasticity, the requirement is not so strict.

In the above described formula, tension has been denotably included. This is because of using the yield strength Y . When one side is extended, if it is assumed that a thickness of the web is t and a width of the web is w , the maximum tension applied to a whole web becomes $Ytw/2$. In case of SUS with a 0.125 thickness and a 356 mm width, this value becomes about 3920 N.

In applying the above described formula, for example, in case of the SUS which the inventors attempted to try to use, it is exhibited that the Y/E value must be suppressed to deformation of about 1.025/1000, namely, 1 mm for the distance of 1 m between the rollers in from and rear positions. Actually, in the apparatus shown in the Fig. 2 (Fig. 3 to Fig. 9,) the axis of the roller causes deformation

of about 5 mm by thermal deformation. On the other hand, in order to keep the distance from the opposite electrode, 980 N tension is applied and thus, it was known that the ear wave is in a situation of very easy occurrence.

Further, when a shift b of the Fig. 1B exceeds a range of elastic deformation of the web (elongated substrate,) the extended side shows plastic deformation and the other side rises from the electrical supply roller, or frequently, both these phenomena simultaneously occur. The plastic deformation of the elongated substrate is inherently deformation of the substrate and therefore, not allowable by following fabrication steps for the solar cell. Besides, in such situation, it is difficult that an area around the elongated substrate is constantly kept against rotative motion of the electrical supply roller. Consequently, in such situation, feeding to the elongated substrate becomes nonuniformly. In addition, in rise of the elongated substrate from the electrical supply roller, it is evident that uniform feeding is not realized. As described above, conveyance, by which the elongated substrate is not subjected to plastic deformation, is necessary for realize uniform feeding.

On the other hand, plastic deformation does not take place, when deformation of the elongated substrate is reduced and therefore, reducing tension of the

elongated substrate is one of options. However, in practice, a smaller tension causes weak collision to the electrical supply roller resulting in lower feeding to the elongated substrate. On the basis of evaluation
5 by using the actual elongated substrate (thickness is 0.125 mm, width is 356 mm, material is SUS 430) used by the inventors, it has experimentally become evident by observation of current flowing from the electrical supply roller to the elongated substrate changing
10 tension that 0.49 N per 1 cm width of the substrate, namely, about 17.4 N for the elongated substrate, is the minimum tension necessary for this the elongated substrate. This tension corresponds to 1/5000 of a force necessary for plastic elongation of the whole of
15 the elongated substrate.

By using the above described treatment, distortion (the web deformation) is expressed as d/L . According to examination by the inventors, in order to inhibit plastic deformation, if it is assumed that the yield
20 strength is Y and the Young's modulus is E for the elongated substrate, it is necessary that the maximum distortion does not exceed Y/E , namely, $d/L < Y/E$. On the basis of this relation, it is needed that the tolerance distortion of the elongated substrate
25 (thickness is 0.125 mm, width is 356 mm, material is SUS 430) is $1.025/1000$. It is 0.125 mm for a 1 m L. If this tolerance distortion is generated by tilting of

the electrical supply roller, deformation of a part between the electrical supply roller and the roller therebefore almost equals to deformation of the part between the electrical supply roller and the roller thereafter and hence, it is enough to consider any one of upstream and downstream rollers.

On the basis of the above examination, in the apparatus of the Fig. 2, the elongated substrate receives tension of 9800 N enough to collide against each roller to conduct a conveyance experiment. By thermal deformation of a frame of the electrodeposition vessel in accordance with rise of the temperature of the electrodeposition bath and tension deformation caused by applying tension to the elongated substrate, the axis of a turning roller 2013 in an entrance of the electrodeposition vessel generates a 1.5-m shift toward the axis of the electrical supply roller, namely, an exhaust roller 2005 of the wind-off apparatus, relatively for the width of the electrodeposition vessel, to present a large variation of a feeding current in conveyance. Hence, as described above, this may cause a small thickness of the film, a high electric resistance, and a microscopic projection due to abnormal growth.

Then, mechanical reinforcement is carried out by making the frame of a bearing part of the roller 2013 in the entrance of the electrodeposition vessel twice

and concerning thermal deformation of the frame of the electrodeposition vessel in accordance with rise of the temperature of the electrodeposition bath, tension deformation caused by applying tension to the elongated substrate, and both of these, the axis of the roller 2013 in the entrance of the electrodeposition vessel is adapted to fall in a range of 1 mm shift relatively against the width of the elongated substrate for the axis of the electrical supply roller, namely, the exhaust roller 2005 of the wind-off apparatus. The distance between the axis of the roller 2013 in the entrance of the electrodeposition vessel and the axis of the electrical supply roller, namely, the exhaust roller 2005 of the wind-off apparatus was 1 m and falls in the range of the present invention. Conveying the elongated substrate in this state showed a very stable and constant feeding current

In other words, in order to supply uniformly and constantly the feeding current, inclination of the axes of the electrical supply roller and rollers therebefore and thereafter is needed to keep to 1.025/1000 (radian) or smaller.

The preferred embodiment of the web conveying apparatus according to the present invention will be described below. The present invention is not restricted to the present embodiment.

A main component of constitution of the web

conveying apparatus of the present embodiment has basically similar constitution to that adopted to the electrodeposition apparatus shown in the Fig. 2 and Fig. 3 to Fig. 9. However, Various improvements have
5 been made to solve a problem of the apparatus.

Therefore, in convenience, description is given with reference numerals similar to those of the Fig. 2 and Fig. 3 to Fig. 9.

The electrodeposition apparatus, which is one of
10 the preferred embodiment of the present invention is the apparatus to make continuously even oxide film, for example, on the web 2006 comprises the wind-off apparatus 2012 to send the web 2006, which has been wound like the coil, out, the first electrodeposition
15 vessel 2066 to deposit or treat a first electrodeposited film, a second electrodeposition vessel 2116 to deposit or treat a second electrodeposited film, the first circulation vessel 2120 to circulate and supply the electrodeposition bath
20 heated to the first electrodeposition vessel, the second circulation vessel 2222 to circulate and supply the electrodeposition bath heated to the second electrodeposition vessel, the first liquid exhaust vessel 2172 to store once for exhausting the
25 electrodeposition bath of the first electrodeposition vessel, the second liquid exhaust vessel 2274 to store once for exhausting the electrodeposition bath of the

second electrodeposition vessel, a filter circulation system (a piping system connected to a circulation filter 2161 of a first electrodeposition vessel filter) to clean the bath by removing powder in the

5 electrodeposition bath in the first electrodeposition vessel, the filter circulation system (the piping system using the circulation filter 2263 of the second electrodeposition vessel filter) to clean the bath by removing powder in the electrodeposition bath in the

10 second electrodeposition vessel, the piping system (the piping system beginning from an orifice 2182 for introducing compressed air) to send compressed air for stirring the bath respectively to the first electrodeposition vessel and the second

15 electrodeposition vessel, the pure water shower vessel 2360 to clean the elongated substrate, on which the electrodeposited film has been deposited, by showering pure water, the first warm water vessel 2361 carrying out first cleaning by rinse with pure water, the second

20 warm water vessel 2362 carrying out second cleaning by rinse with pure water, a pure water heating vessel 2339 to supply warm pure water necessary for these warm water vessels, the drying part 2363 to dry the web cleaned, the wind-up apparatus 2296 to wind up the web,

25 of which film deposition has been deposited, in a coil shape again, and an exhaust system (exhaust system comprising the electrodeposition washing system exhaust

duct 2020 or a drying system exhaust duct 2370) for steam generated in the heating stage or the drying stage of the electrodeposition bath and pure water.

In other words, the electrodeposition apparatus according to the present invention is that made by adopting roll-to-roll system to convey the web 2006 across rolls and for example, equipped as the main constitution component of the electrodeposition apparatus and thus, the web 2006 across rolls is flown from left to right in the Fig. 2, in order of the wind-off apparatus 2012, the first electrodeposition vessel 2066, the second electrodeposition vessel 2116, the pure water shower vessel 2360, the first warm water vessel 2361, the second warm water vessel 2362, the drying part 2363, and the wind-up apparatus 2296 to deposit a predetermined electrodeposited film

Particularly preferable is that the elongated substrate receives tension and also is conveyed in the form of partial winding around the electrical supply roller, which feeds or receives all currents for electrodeposition through feeding means, to be conveyed and inclination of the axes of the electrical supply roller and rollers therefore and thereafter during conveyance thereof is kept to the predetermined angle or smaller which is determined based on the ratio of the yield strength to Young's modulus of the substrate.

Each constitutional component will be described below in detail.

[Web]

5 The web (elongated substrate) applied to the present invention are exemplified as applicable by metal such as stainless steel (SUS), iron, copper, aluminium, and brass, or those prepared by plating on a surface of them, and also paper and resin. However, paper and resin have a large elasticity range and
10 therefore, particularly effective in case of small distance between rollers. Basically, a constant of a material of a web material is important and a surface property does not so much influence to.

For the web (elongated substrate)
15 electrodeposition material used for the apparatus shown in the Fig. 2, those electrically conductive to the surface of the film prepared and noncorrosive by the electrodeposition bath can be used and exemplified by metal such as stainless steel (SUS), Al, Cu, and Fe.
20 Those coated with metal such as a PET film can be also applied. Among these materials, SUS is excellent as the elongated substrate for preparing a device in a postprocessing.

As SUS, both nonmagnetic SUS and magnetic SUS can
25 be applied. The former is represented by SUS 304 excellent in grindability to allow making to a mirror face with about 0.1 s. The latter is represented by

SUS 430 of a ferrite series, effectively used for conveyance by applying a magnetic force.

5 The surface of the substrate may be smooth or coarse. In rolling process for SUS, changing a kind of a rolling roller causes a change of surface properties. That called BA has a near-mirror property and 2D shows a prominent irregular surface. In either surface, observation by employing an SEM (scanning electron microscope) a microscopic hollow is occasionally found.
10 As a solar cell substrate, rather than a large wavy irregular surface, a microscopic structure is reflected largely to characteristics of the solar cell better or worse.

15 In addition, in these substrates, another conductive material may be prepared as the film to select for a purpose of electrodeposition. Occasionally, forming previously a very thin layer of zinc oxide by another method is preferable for improving stably the speed of deposition by the
20 electrodeposition method. Certainly, the electrodeposition method has a merit of a low cost. However, even if a costly method is applied additionally, when total reduction of the cost is possible, a combined use of these two systems is
25 advantageous.

[Tension]

Tension to stretch the elongated substrate across

a bobbin 2001 of the elongated substrate of the wind-off apparatus and a wind-up bobbin 2289 for the elongated substrate is assigned to 0.49 to 490 N per 1 cm substrate width. When tension is smaller than 0.49 N, the substrate is suddenly hung down, moves to outside of a predetermined conveying path, scratches an edge by moving out from the roller, or controllability of snaking correction is worsened distinctly. On the other hand, excessive tension causes expansion of the substrate itself, or there is a deviation of conveyance, as described above, only the edge elongates to make a form similar to a thallus of *Undaria pinnatifida* (a brown alga) or make distortion of a whole apparatus.

More preferable tension applied to the web, which is employed in the present invention, is specified by settable value selected from values ranging from around 98 N to around 1176 N for the web made of SUS of the 0.125 mm thickness and the 356 mm width. Needless to say, tension set large requires a rigid frame corresponding to the roller axis, which supports the frame. Shift of the roller axis preferably ranges from 0.1 mm to 0.3 mm or less. Better means can be adjusting the roller axis in the state of applying tension. In this case, a time sequence must be watched.

Tension can be generated by sliding of a force to wind up the wind-up bobbin 2289 for the elongated substrate and a crutch (a powder crutch and the like are effectively used) fitted to the axis of the bobbin 2001 of the elongated substrate of the wind-off apparatus. In this case, in spite of magnitude of tension, the conveying path does not almost change and intermediate rollers can be all assigned to the follower roller and therefore, freedom of designing arrangement of components, such as the roller, configuring conveyance system is very high; on other hand, at the time of no conveyance, no tension occurs and thus, for prevention of hanging down of the substrate in a still state, other lock means is necessary.

Tension can be generated also by using a tension roller and the like capable of moving the axis thereof. In this case, controlling and monitoring tension can be readily performed; however, the position of the tension roller changes and hence, the design to keep a stroke thereof is required and the degree of parallelism of the roller changes to generate snaking.

Further, tension can be generated by moving positively an intermediate roller to a direction causable of friction with the substrate. This method presents an advantage that the conveying path is not changeable and works in a stilled status. On the other

hand, the material, of which dynamic friction differs greatly from static friction, does not allow easy designing.

5 Tension, needless to say, influences to the roller
contacting with laterally rather than the roller
conveyed in the form covering largely over a
circumference thereof. Those expectable effects
thereof are exemplified by the electrical supply roller
and a snaking-correction roller as well as the wind-up
10 roller.

[Roller]

The roller used for the apparatus shown in the
Fig. 2 must satisfy functions such as determining the
conveying path of the elongated substrate, and also
15 applying an electric potential necessary for the
elongated substrate, and no formation of a current
stray path unnecessary.

Determination of the elongated substrate is
particularly important. A degree of parallelism must
20 be, needless to say, in an early stage is and even if
the temperature of the electrodeposition bath rises to
a high temperature such as 90°C to cause thermal
expansion of a large bath vessel, displacement of a
position must be suppressed to a minimum degree.

25 Practically, back lash of a submillimeter order can be
allowed; however, for the parallelism, it is preferable
that precision of the order of 100 minutes is kept at

the time of rising of the temperature. The difference in the degree of parallelism and twist cause particularly a deviated position of the elongated substrate in the electrodeposition vessel and then, scratch and the wavy form of the *Undaria pinnatifida* thallus edge occurs very frequently. However, as described in examination of the present invention, in plastic deformation, distortion becomes a problem. Therefore, in case of the large distance between rollers, inclination, namely the degree of parallelism, of the roller axis is not so important cause.

If there is withy in the elongated substrate, the roller is a parallel roller and thus, surface processing is not especially necessary. However, in case of a soft substrate such as an Al foil, it is better to swell the roller in a form of a Japanese drum named crown or to make a groove for draining. In such case, tension enough for follow of the roller is not applied and therefore, to avoid it, synchronous driving of the roller brings an effect.

In order to lift electrically, the roller can be prepared with a resin such as nylon or polyethylene and also, the axis of a metal roller can be prepared with the resin, and in addition, a resin member is put between parts, where the bearing has been installed, to realize insulation.

Unless feeding to the substrate is directly

carried out by a brush, or feeding is carried out through a bath, it is better to install at least 1 roller applying the electric potential and named the electrical supply roller. If the roller near the electrodeposition part is assigned to the electrical supply roller, an electric path related to an electrodeposition current can be most simply designed. In the case where a chemical substance in the bath makes a reaction by touching with the bath and then, the electrical supply roller cannot be put around the anode, such other system as brush-feeding or bath-feeding have to be considered for replacement or a combined use. This is because a resistance of the elongated substrate is about 0.01Ω a meter and therefore, when some ten ampere of electrodeposition current is used, very large thermal loss occurs.

For snaking correction, as a concept, it is better that the conveying system having almost no shift is established by making the degree of parallelism of the roller and a only small shift is corrected immediately wind-up. Correction is detected to return to the snaking-correction roller through a feed forward system or feed back system. The feed forward system, for which calculation is complicated, is relevant to a high speed system exceeding some meters per second and the feed back system, inappropriate for high speed conveyance, contributes to simplification of

configuration.

In such all cases, it is preferable that the snaking-correction roller, which moves the substrate in the direction of correction, is installed. In the apparatus of the Fig. 2, a direction-switching roller 2287 (refer to the Fig. 7) for the wind-up apparatus works for such operation. Preferably, to move the substrate in the direction of correction, friction with the elongated substrate is larger. On the other hand, in order to absorb the distortion of the elongated substrate caused by correcting motion, preferably, the elongated substrate slides on the roller for snaking correction. A magnitude of friction applied practically is experimentally determined including tension. Occasionally, the effect can be yielded by selecting the material to optimize friction with the substrate and processing to make the surface coarse. In order to move the substrate in the direction of correction, configuration may be build up to allow the whole roller to move in parallel and may allow a shape (named a tangent roller) to do oscillation motion around the axis, in a certain distant position, as the fulcrum. The parallel motion roller presents the effect to the large shift and on the other hand, the tangent roller allows the simplified configuration of the apparatus.

[Supply roller]

The material of the supply roller applied to the present invention is not restricted as long as it can hold the web, and can apply a certain tension to the web by breaking against a wind-up force of the wind-up roller, and then can control a supply speed of the web. Breaking is normally by a crutch installed coaxially in the roller. Control of the supply speed is carried out by feed back a speed, which is detected by the speed sensor and a rotation encoder, to the driving system of the wind-up roller.

[Wind-up roller]

The preferable wind-up roller applied to the present invention is that capable of conveying wind-up of the web by motor drive, and more preferable is that capable of controlling the rotation speed by the servo. In this case, a rotation speed signal from the supply roller can be fed back. Around the wind-up roller, the web passed through a snaking correction system is wound and thus, the edge is become that arranged. It is preferable that the conveying speed of the web wound up by the wind-up roller meets a speed of 200 mm to 500s mm per minute.

[Follower roller]

In the preferable follower roller applied to the present invention, the surface rotation precision must not exceed 1 mm to the distance of 1 m between rollers and preferably 0.3 mm or small. This is the distance

including eccentric distance of the axis and hence, when a soft resin made bearing is used, this allowance may be exceeded by a temporal change. If possible, the bearing used is preferably of SUS-made or the like.

5 The surface of the roller can be made of metal and also such resin as nylon; however, for example, the roller installed in the electrodeposition vessel is influenced by a solution, temperature, and tension and then, may cause rheological deformation beyond the allowance.

10 Therefore, this has to be cautioned.

It is important that the surface of the roller has a somewhat large friction with the web to disturb sliding. Therefore, the surface material used is nylon and SUS. In consideration of the surface quality of
15 the web, if sliding is easy, a stronger tension should be applied.

[Axis inclination-controlling means]

Axis inclination controlling means employed in the present invention is exemplified by an electric servo
20 and a hydraulic servo or the like. Particularly, to give inclination of 1/1000 or fewer, a stroke of 1/1000 web width, i. e., normally from some ten micrometers to some hundred micrometers must be assured. Other useful system is to install a doctor guide in an upper limit
25 and a lower limit and meet it with a top and a bottom.

In order to feed back a necessary signal for axis inclination controlling means, detection means is

generally required. In this detection means, detecting the shift of the web is preferable and therefor, a laser edge position sensor and an eddy current and a magnetic sensor are applicable. The edge position of the laser sensor, even either a reflection type or a transparent type, is suitable for the case requiring precision. The eddy current sensor is preferable in the case of a limited space for installation of the sensor. The magnetic sensor presents the effect to the magnetic web.

Preferably, the shift of the web caused by these detection means is set to have precision of at least some ten micrometers, preferably from 10 to 20 micrometers. These values can be set by using the above-enumerated sensors.

[Electrodeposition bath]

The electrodeposition bath examined by using such small experiment apparatus as beaker can be used. Concerning zinc oxide deposition having irregular surface and having optical confinement effect applied to an underlaying layer of the solar cell, the solution disclosed in Japanese Patent Application Laid-Open No. 10-195693 can be used. In case electrodepositing zinc oxide, a combination of zinc nitrate with an additive is preferably used and when the additive is a sugar, homogeneity of the film increases. Specifically, dextrin shows a prominent effect thereof.

In the case where the electrodeposition bath is high in temperature and generation of steam is vigorous, as shown in the Fig. 2, aspirating steam by installing a exhaust duct is preferable because exhaust of steam and water drop, made by condensation thereof, from the space in the apparatus can be prevented. In addition, when a lid not illustrated is installed in the vessel, steam dangerously blows out when the lid is removed and hence, installation of the exhaust duct is particularly recommended. In the case where a liquid volume is reduced by generation of steam by the electrodeposition bath and aspiration of exhaust, it is better to add pure water periodically.

[Condition of electrodeposition]

For electrodeposition, negative and positive electric potentials are applied to the elongated substrate and the anode, respectively to accelerate an electrochemical reaction. In order to carry out control of the film thickness, electrodeposition by current regulation is preferable. It is preferable to designate the electric current by a density and designation is done in a range from 0.3 to 100 mA/cm².

[Anode]

As the anode, a zinc plate of purity from 2 N to 4 N can be used as a soluble anode. In the case where the surface has been contaminated, it is better to wash lightly with nitric acid. It is preferable that a

feeding line to the anode is configured by tightening with a SUS bolt for assuring reliable electric contact during a long term. As an insoluble anode, SUS and Pt can be used.

5 Particularly, wrapping the soluble anode in an anode bag preferably prevents the generated zinc oxide powder from being dispersed into the electrodeposition bath. As the material of the anode bag, cotton and amide resin fiber noncorrosive in the bath can be used
10 and preparing it in a proper mesh structure is preferable. The size of the mesh is determined by designating the maximum size of power, of which surface is reliably contacted with the electrodeposition bath, generate dust. Normally, the size ranging from 0.5 mm
15 mesh to some millimeters mesh is selected.

[Electric power supply for electrodeposition]

 Preferably, each electric power supply has a float output. In voltage regulation, in the case where a predetermined electric potential is applied, when there
20 is a possibility of a flow of the current to a suction direction, a suction type power supply has to be adopted. Each power supply applies the electric potential to a single or a bundled plurality of anodes to flow the current. To prevent interference between
25 power supplies, appearance of the current path to link anodes is preferably prevented as far as possible. For this purpose, installing such insulation plate as

Teflon or vinyl chloride in the bath is effective.

Examples according to the present invention will be described below.

[Example 1]

5 An ear wave-preventing apparatus according to the present invention has been assembled in a returning roller 2016 between the electrodeposition vessels of the Fig. 2. Fig. 10 shows attitude thereof.

10 In the Fig. 10, reference numeral 3005 denotes the returning roller 2016 (refer to the Fig. 4) between the electrodeposition vessels of the Fig. 2. In this roller 3005, the roller axis 3004 thereof is supported by the bearings 3003 and 3008. The bearing 3003 is installed in the frame of the apparatus 3001. The
15 other bearing 3008 is installed in a bracket 3010. In the bracket 3010, a slider 3012 of an LM guide comprising the slider 3012 and a rail 3011 has been installed. The rail 3011 of the LM guide is installed in the frame 3002 of the apparatus. According to this,
20 motion of the bracket 3010 is limited to vertical motion. Therefore, the roller axis 3004 moves similar to an arrow 3009 around the bearings 3003.

 On the other hand, the bracket 3010, of which fixed end has been connected to an operation end of the
25 electric servo 3013 installed in the frame 3002, is received a servo-working signal and gives a motion of

the arrow 3014 and thus, controls inclination of the above described roller axis 3004.

Detection of a web position is carried out by an eddy current displacement sensor 3016 mounted on a
5 sensor supporting stand 3015 connected to the bracket 3010. An output of the eddy current displacement sensor 3016 is sent to a sequencer through a sensor amplifier 3017 and an analog controller 3018 as a web position signal.

10 Near the roller 3005, a cover 3007 is located to prevent to escape steam from the electrodeposition bath and also prevent drying of the web, and prevent attaching of dust to the web.

Components used by the inventors are specifically
15 recorded as follows: the eddy current displacement sensor 3016 was a sensor EX022 manufactured by KEYENCE Corporation, the amplifier 3017 was EX510 manufactured by the same corporation, and the analog controller 3018 was RDE50E manufactured by the same corporation.

20 Advantages of the eddy current displacement sensor are installability in a small place, a good temperature characteristics, tolerability against introduced steam, and the like and preferably meets the followings: the cover is put over the returning roller 2016 between the
25 electrodeposition vessels to inhibit to keep an enough space, the temperature of the electrodeposition bath is raised to 95°C, and steam from the electrodeposition

bath may be introduced. On the basis of combination of the present sensor with the amplifier, shift of the web in the lateral direction ranging to 10 mm is converted to the voltage ranging from 0 to 10 V to output it.

- 5 Resolution is 0.1 mm or higher and satisfactory for the purpose of the present invention.

The electric servo 3013 used was MSM022AIF made by Panasonic. Continuous operation is possible; however, herewith, a stopper was used to make 3-value action
10 with ± 0.3 mm (including a neutral point.) The electric servo can be made in a small size to be convenient for installation on the bracket as in the present Example. If a weight of the roller is large, the hydraulic servo can be used. As the LM guide, SR30TB made by THK
15 Corporation was used. The stroke was enough including freeplay at installation.

Feed back of the servo by the controlling system of the sequencer comes in a center of the servo in the case, where the output from the eddy current
20 displacement sensor is ± 1 mm, and comes in just 0.3 mm of a reverse direction in exceeding 1 mm.

The above described roller axis inclination controlling system is incorporated in the electrodeposition apparatus shown in the Fig. 2 and in
25 the state of the temperature of the electrodeposition bath being a room temperature, the web was manually set. Thereafter, tension of about 980 N was applied to

the web to convey preliminarily. At this time, all the roller had completed alignment in horizontal direction. As a result of preliminary conveyance, unless the roller axis inclination controlling means according to
5 the present invention is worked, good conveyance was yielded. Shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, fell in about ± 2 mm and the web was wound in the coil form having the
10 arranged edge of the web.

Subsequently, the temperature of the electrodeposition bath was raised to 85°C ; the electrodeposited film was deposited to carry out conveyance of the web. Then, shift of the web in the
15 part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, increased to about ± 6 mm and thus, though snaking of the web can be corrected, the ear wave occurred and a following process did not allow it.
20 When tension was reduced to about 588 N, shift of the web reduced to ± 5 mm; however, the ear wave was inherently left unremoved.

Then, the roller axis inclination controlling means as described above as the present example was
25 worked and then, after 10 minutes, snaking of the whole web reduced and shift of the web in the part, of which snaking was corrected by using the direction-switching

roller 2287 for the wind-up apparatus, fell in about ± 2 mm and as the result, the web was wound in the coil form having the arranged edge of the web.

5 The film electrodeposited faces to a face, in which shift is corrected by an inclination angle-controlling roller. However, the roller is the follower and the force in the direction of scratching on the film surface does not work (the web is conveyed facing closely to the roller) and therefore, crack and
10 crush never occurred to influence to a function.

[Example 2]

The same control system as that incorporated in Example 1 was employed by modifying only a feed back system of the servo to a continuous system shown in the
15 Fig. 11.

The web was set when the electrodeposition bath was in the room temperature. The preliminary conveyance showed good conveyance similar to Example 1 including wind-up without the ear wave. Next, the web
20 conveyance was carried out after the temperature of the electrodeposition bath was raised to 85°C and then, similar to Example 1, shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus,
25 increased to about ± 6 mm. Subsequently, the roller axis inclination controlling means was worked and then, after 5 minutes earlier than Example 1, snaking of the

whole web reduced and shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, fell in about ± 2 mm and as the result, the web was wound in the coil form having the arranged edge of the web.

[Example 3]

The same control system as that incorporated in Example 1 was incorporated in a returning forwarding roller 2279 (refer to Fig. 7) of the pure water shower vessel of the electrodeposition apparatus shown in the Fig. 2.

It is similar to Examples 1 and 2 that the preliminary conveyance was good and immediately after the temperature rise to 85°C , shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, increased to about ± 6 mm. Subsequently, the roller axis inclination controlling means was worked and then, after 10 minutes, snaking of the whole web reduced and shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, fell in about ± 1 mm and as the result, the web was wound in the coil form having the arranged edge of the web.

In a mode of the present example, rise and drop of the temperature of the electrodeposition apparatus is repeated and therefore, it was observed that the roller

axis having been aligned to be parallel gradually changes in the time sequence. An average inclination of roller axes was about 1.5 mm to the web width. In this case, even in room temperature state of the bath, 5 snaking of the whole web reduced and shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, fell in about ± 3 mm and though the ear wave did not occur, in comparison with a state before the 10 change in the time sequence, snaking enhanced.

Consequently, at temperature rise of the bath, correction of snaking and prevention of the ear wave is further required. Actually, in this example, when both the inclination controlling means of the present 15 invention are turned to OFF, a part of the web is caught by an electrode frame and thus, conveyance was substantially impossible. In addition, in case where the one only was worked, shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, fell 20 in about ± 5 mm and conveyance and wind-up were possible; however, the ear wave could not removed even by reducing tension. In contrast to this, in the case where both the inclination angle-controlling measures 25 was worked, shift of the web in the part, of which snaking was corrected by using the direction-switching roller 2287 for the wind-up apparatus, fell in about ± 2

mm and preferable conveyance and wind-up were possible without occurrence of the ear wave.

[Example 4]

By using the electrodeposition apparatus shown in the Fig. 2 (from Fig. 3 to Fig. 9,) and the present invention is applied to this to prepare the solar cell 4001 shown in the Fig. 12. In the Fig. 12, The reference numeral 4002 is the substrate, 4003 is a reflection metal layer, 4004 is a spattered zinc oxide film, 4005 is the electrodeposited zinc oxide film, 4006 is an n type layer, 4007 is an i type layer, 4008 is a p type layer, 4009 is an ITO layer.

As the substrate 4002, the elongated substrate having a 2D surface of the 0.125 mm thickness, the 356 mm width, and a 1050 m length (distortion allowance = 1.025/1000) was used and using an elongated substrate-spattering apparatus not illustrated, a 2000 Å aluminium thin film 4003 and subsequently a 1700 Å zinc oxide thin film 4004 were deposited by spattering. This was set in the electrodeposition apparatus of the Fig. 2. The electrodeposition bath containing zinc nitrate of a 0.2 mol/L concentration and 0.07 g/L dextrin was circulated in a first electrodeposition vessel 2066 and a second electrodeposition vessel 2116 and kept the temperature thereof to 85°C, respectively.

In the substrate 4002 set in the electrodeposition apparatus of the Fig. 2, the conveyance speed was 500

mm/min, tension was 588 N (about 16.5 N per 1 cm substrate width) and all anode current (a sum of currents flowing in all anodes located in the first electrodeposition vessel 2066 and the second electrodeposition vessel 2116) of 176 A was fed (practically, the direction of the current is the direction from the substrate toward the electrical supply roller and hence, receiving is a correct expression; however, the anode is herewith needless to distinguish from cathode and therefore, currents of either directions are named "feeding") from the exhaust roller 2005 of the wind-off apparatus used as the electrical supply roller to electrodeposit continuously the zinc oxide film, 4005. Then, shift of the axis of the rollers before and after the electrical supply roller are both 0.7/1000 or smaller and the elongated substrate showed shift of the conveying path of the maximum 2 mm, showed snaking better corrected, and wound up around an elongated substrate wind-up bobbin 2289 in a ± 3 mm precision.

Subsequently, the elongated substrate, on which the electrodeposited zinc oxide film 4005 was formed by such manner, was set in a elongated substrate CVD film preparing apparatus not illustrated to form sequentially and continuously a 300 Å n type amorphous silicon layer 4006, a 2000 Å i type amorphous silicon layer 4007, and a 200 Å p type microcrystal silicon

layer 4008. Subsequently, using the elongated substrate-spattering apparatus not illustrated, a 660 Å ITO film 4009 was formed to yield the solar cell 3001 of the configuration shown in the Fig. 12.

5 The elongated substrate completed was sampled in the length direction, an output electrode was configured as the solar cell under an AM 1.5 imitation sunray to evaluate thermal conversion efficiency by IV measurement and on the basis of deviation thereof
10 applicability of the electrodeposition layer was evaluated by the electrodeposition apparatus of the Fig. 2. Actually, solar cell could be formed in 800 m part of the 1050 m elongated substrate, because a leader part of the apparatus is essential. The solar
15 cell conversion efficiency was examined for this 800 m and then, almost stable production ranging from 7.5 to 7.9 percent was possible.

[Comparative Example]

 For comparison, as identical experimental
20 combination to Example 1, in the status, in which shift of the roller axes before and after the electrical supply roller is 1.5/1000 before reinforcing
 modification of an axis support of the returning roller
2013 in the entrance of the electrodeposition vessel,
25 the solar cell of the Fig. 12 was prepared for 800 m length by the same method. For this 800 m part, the solar cell conversion efficiency was examined by a

similar manner to Example 4 and then, average value ranged from 7.4 to 7.9 percent. However, in a proportion of once per some ten meters, a shunt, efficiency decreased by deficiency of a current density, and the like were found. On the basis of examination by the inventors, this may be because abnormal growth and the part with a thin electrodeposited zinc oxide layer were generated on the zinc oxide film formed by the electrodeposition method using the electrodeposition apparatus of the Fig. 2. As above described, the effect of application of the present invention is evident from the comparison of Example 4 with this Comparative Example.

[Example 5]

Tension of the substrate installed in the electrodeposition apparatus of the Fig. 2 (from Fig. 3 to Fig. 9) in Example 4 was increased to a range from 588 N to 980 N (about 27.5 N per the 1 cm substrate width) to prepare a similar solar cell. Shift of the exhaust roller 2005 of the wind-off apparatus, used as the electrical supply roller, from the axis of the rollers before and after the electrical supply roller were increased up to 1.0/1000 and contact with the electrical supply roller of the substrate showed further improved reliability for that length. By this, the solar cell for 800 m length shown in the Fig. 12 was prepared through the process same as Example 4.

The solar cell conversion efficiency for 800 m was 7.6 to 8.0 percents somewhat increased than Example 4. From examination of IV characteristics, this is caused by short current density J_{sc} improved. In the

5 electrodeposition apparatus shown in the Fig. 2, tension increased for the elongated substrate caused stable state of the distance between anode substrates for a long period on the basis of almost no influence by stirring of the bath for a long time. Therefore,

10 stable formation of the electrodeposited zinc oxide film was realized.

[Example 6]

Thickness of the SUS substrate used was increased to the range from 0.125 to 0.15 mm. This is for a main

15 purpose to increase independence as the solar cell. However, a size of the coil restricted the length allowing formation of the solar cell film to 600 m.

At this time, deformation allowance, namely, allowance of shift of the axis of rollers before and

20 after the electrical supply roller, according to the present invention does not change. Changeable is tension causing the same change. In other words, the present example requires 1176 N tension not 980 N to bring the same deformation of the substrate as that of

25 Example 5. Increase in tension causes a larger deformation of the roller axis. However, increase in rigidity of the frame supporting the axis is not

realistic and therefore, the distance between rollers was let meet the range from 1 m to 1.5 m. According to this, the maximum distortion fell in 0.8/1000 and did not exceed the predetermined Y/E .

5 Conveying the elongated substrate, set according to the above described method, was very preferably carried out and formed the solar cell shown in the Fig. 12, similar to the Fig. 5. Evaluation of conversion efficiency for 600 m showed 7.7 to 8.0 percents, which
10 is a value more stabilized than Example 2. This is because the substrate becomes withy and hence, a mechanical precision was improved for the opposite electrodes as like as the electrodeposition apparatus shown in the Fig. 2.

15 As described above, according to the web conveying apparatus according to he present invention, as described in analysis and examples, in forming the functional film, the conveyance system, by which the web to be treated in a wound form like the coil can be
20 conveyed in the predetermined speed, without the ear wave, keeping the distance from a film-forming opposite electrode, and without snaking, can be provided in the form capable of incorporation in the film-fabricating apparatus.

25 On the other hand, this system has the snaking correction means and the inclination control means of the arc motion roller and thus, even if inclination of

the roller axis occurs according to the temperature change, tension change, and temporal change, the conveying system capable of wind-up the web, without the ear wave and snaking, can be provided.

5 In addition, the servo feed back controls the noncontact sensor and a plurality of discrete control amounts and therefore, the detection part can be installed in a smaller space and also a simple algorithm realizes control.

10 Further, by controlling a consecutive feed back amount by the servo feed back, a response time from shift of the web to return to the predetermined path can be made short.

 And, the maximum control by the inclination
15 control means does not exceed the yield stress of the edge of the web and therefore, the ear wave is not caused by the inclination control means

 According to the present invention, the zinc oxide film allowing flow of the current for electrodeposition
20 to the elongated substrate uniformly and stably, without occurrence of abnormal growth, and uniform film thickness and electric resistance can be continuously electrodeposited.

 Also according to the present invention,
25 application of tension of 0.49 or higher a 1 cm width of the elongated substrate allows preventing rise up of the elongated substrate from the electrical supply

roller and allows preventing occurrence of reduction,
caused by no flow of the current, of the film
thickness. Consequently, the uniform zinc oxide film
can be electrodeposited continuously across the length
5 direction of the elongated substrate.

Furthermore, the present invention can, by making
inclination of the axis of the electrical supply roller
and the rollers therebefore and thereafter $1.025/1000$
(radian) or smaller, make an area around the electrical
10 supply roller in both sides of the elongated substrate
uniform, the uniform current can be kept across a width
direction of the elongated substrate, and therefore,
the zinc oxide film uniform in the width direction can
be electrodeposited continuously.

15